KLIK-FAST®

marson

FASTENERS

Rivets, inserts & setting tools

QS 9000 / ISO 9002 CERTIFIED

www.marsoncorp.com

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We will achieve business excellence by:

- *Encouraging and expecting the creative involvement of every employee.*
- *Listening to our customers and meeting their needs.*
- *Continuously improving our processes, products and services.*

About Marson

Today, Marson Corporation is one of the largest manufacturers and suppliers of blind rivets, threaded inserts and rivet setting tools in the United States. With the introduction of Klik-Fast® rivets in 1959 and the HP-2® hand rivet tool in 1961, Marson laid the foundation for its entry into the blind fastener and tool marketplace. Marson Corporation's success has been and will continue to be based on a commitment to providing its customers with the best quality products and services available. As the needs of industrial customers have changed, Marson has invested in its people, equipment and technology necessary to continue this tradition.

Marson offers the broadest line of blind fasteners for industrial and automotive applications in the industry. The breadth of the line is supported by a nationwide network of independent stocking warehouses, maintaining inventories that can deliver product to customers within hours if necessary. In short, Marson's responsiveness to its customers and the needs of industry is second to none.

In an ongoing effort to be the best, Marson offers custom services such as painting, plating, anodizing, packaging, bar-coding and labeling. Add to this Marson's strong commitment to research, design and development and you have an unbeatable combination. Marson's reputation for innovation, reliability and service stands strong as we continue to develop and deliver the best products and services available to our valued customers.

Quality Policy

Marson Corporation operates under a Total Quality Management System philosophy, strictly adhering to QS-9000 and ISO-9002 guidelines. As a result, the focus is on quality as a top priority in all phases of operation, ensuring complete customer satisfaction.

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General Information

Rivet Styles	Features/Benefits	Materials Available
Open End	• For blind fastening where there is no access to opposite side of work • Simple to install • Wide variety of head styles and lengths available from 3/32" to 1/4" diameters	Steel/steel, Aluminum/aluminum Aluminum/steel, Stainless/stainless Stainless/steel, Copper/brass, Copper/steel
Closed End	• Moisture-resistant due to tight seal • Greater shear and tensile strength • Mandrel is retained 100% of time • 1/8" to 1/4" diameters	Aluminum/steel, Aluminum/aluminum, Stainless/stainless
Multi-Grip	• Extended grip range capacity • Reduces inventory (fewer sizes required) • Use as a standard open end rivet • 1/8" to 3/16" diameters	Aluminum/steel, Steel/steel
Q-Lok	• Retained mandrel increases shear and tensile strength • Use in high vibration applications • Mandrel breaks flush when used in mid-grip range • Moisture-resistant due to tight seal • 1/8" to 3/16" diameters	Steel/steel
Klik-Lock	• Permanently retained mandrel provides increased shear and tensile values • Use in high vibration applications • Provides weather-resistant joint • Available in 3/16" and 1/4" diameters	Steel/steel, Aluminum/aluminum, Stainless/stainless
T-Rivets	• High clamp up • High shear strength • Creates a wide bearing surface • 1/4" diameter	Aluminum/steel
Special Application Rivets	• Small flange rivet used primarily for fastening decorative materials on boats, automobiles, trucks & other motor vehicles • Best suited to applications where a discreet, secure installation of non-critical components is needed.	Stainless/steel, Aluminum/aluminum
Plastic	• Precision-molded, all-nylon • Secure lock prevents pull-out • Fasten plastic to plastic, plastic to metal or plastic to fiberglass	

Selecting the Correct Klik-Fast Rivet

Marson Corporation offers a full line of headed rivets for general consumer and industrial applications. The materials and manufacturing processes used to head rivet bodies increase their shear and tensile values over a stamped eyelet-style rivet. These easy-to-use rivets are used to fasten together two or more pieces of material of varying thickness.

The rivet body alloy, in addition to being chosen for strength requirements, should also be selected for compatibility with the materials to be joined to avoid galvanic corrosion caused by coupling dissimilar metals. If dissimilar metals are widely separated on the galvanic chart, it is advisable to separate them with a dielectric material such as paint or other coating.

Head Styles	Features/Benefits
Buttonhead	• Low profile head diameter is twice the rivet body diameter, providing adequate bearing surface for nearly all applications • Open-end buttonhead rivets offer the broadest selection of sizes available.
Large Flange	• Provides greater bearing surface for fastening soft and brittle facing materials and oversize facing holes • Works well with soft materials, where the increased flange diameter protects the integrity of the application
Countersunk	• 120° countersunk rivets for applications where flush appearance is required

Design Information

Rivet Code Definitions

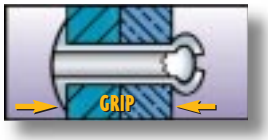
Example:
ABL6-6A

A — First Letter .....Rivet material (A - Aluminum, S - Steel, C -Copper, SS - Stainless Steel)
B — Second Letter .....Style of Head (B - Buttonhead, C - Countersunk)
L — Third Letter (if any) .....Large Flange Head
6 — First Number .....Body Diameter in 32nd's
6 — Second Number .....Maximum Grip Length in 16th's
A — Final Letter (S).....A - Aluminum Mandrel, S - Stainless Steel Mandrel, B - Brass Mandrel, C - Copper Plated Steel Mandrel, CLD - Closed-End, MG - Multi-Grip, QL - Q-Lok, KL - Klik-Lock. No letter indicates steel mandrel.

Design Information

1. The shear and tensile strength of the rivet selected and the number of rivets used in the application should equal or exceed the joint strength requirements. Typical ultimate shear and tensile strengths are listed by diameter and alloy on pages 5 through 16 of this catalog. Testing is recommended before final selection and use in product.

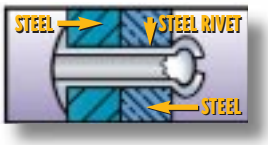
2. The rivet body material should be compatible with the materials to be joined to resist galvanic corrosion which may result in reduction of joint strength. If dissimilar materials are widely separated on the galvanic chart, it is advisable to separate them with a dielectric material such as paint or other coating. Marson can paint colors to match, as well as anodize or plate to your specifications.



3. After determination of strengths required by diameter and alloy, the total thickness of materials to be joined must be considered. The grip range for each rivet is listed on pages 5 through 16. Select the rivet grip range which includes the total thickness of materials to be joined. Please note that the rivet barrel length (Column L) is not the grip range.

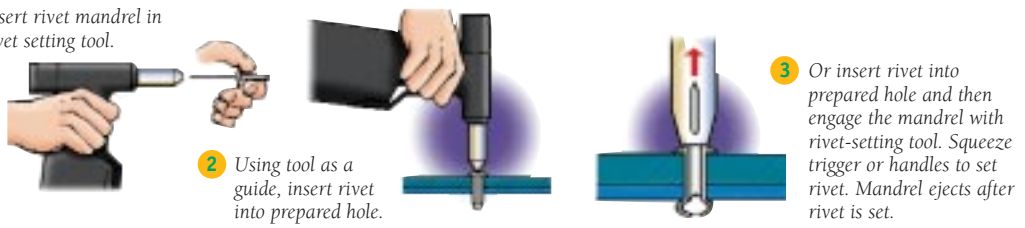
4. Recommended hole sizes listed for each rivet diameter on pages 5 through 16 should be followed closely. An undersize hole will not allow insertion of the rivet body; an oversize hole will reduce shear and tensile strengths, and may cause improper rivet setting, all of which promote joint failure.

5. The various head styles (illustrated page 3) are offered to accommodate different assembly needs. The most popular Klik-Fast rivet is the buttonhead, whose lower-profile head is twice the diameter of the rivet body. This provides adequate bearing surface for nearly all applications. The large flange Klik-Fast rivet provides greater bearing surface for fastening soft or brittle facing materials. The countersunk Klik-Fast rivet is available for applications where a flush appearance is required. And the closed-end is ideal for electric or electronics applications.



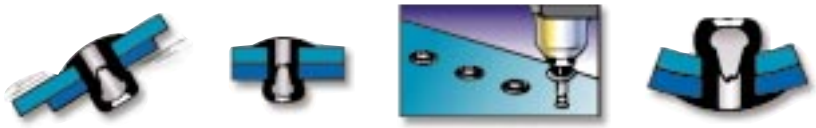
6. Besides the sizes, alloys and head styles listed, Marson manufactures a wide range of special rivets to accommodate a variety of customer needs for strength, head style and grip range. You are invited to send your applications questions or problems to Marson headquarters for evaluation, testing and recommendations.
   - Samples are available upon request.
   - Special packaging needs are quickly and easily met.

To install

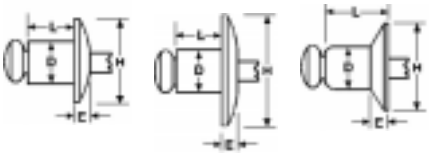

1 Insert rivet mandrel in rivet setting tool.
2 Using tool as a guide, insert rivet into prepared hole.
3 Or insert rivet into prepared hole and then engage the mandrel with rivet-setting tool. Squeeze trigger or handles to set rivet. Mandrel ejects after rivet is set.

Features, benefits & applications

One Length Handles Both — *Hollow Extrusions and Tubes* — *High Grip Strength No Surface Distortion* — *Hard and Soft Materials*



Vibration and Tamper Resistant — *High Strength* — *No Marred Surfaces* — *Low-Profile Heads*



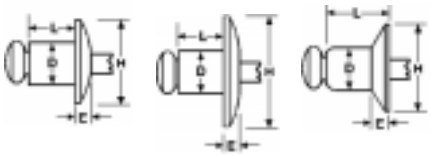
Steel Rivets

Plated-Steel Rivet • Coated Steel Mandrel • IFI Grade 30

Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
Buttonhead										
SB3-2	3/32"(.094)	#41(.097-.100)	.188	.032	.250	6.4	.032-.125	0.8-3.2	160	200
SB3-4	2.4	2.5(2.46-2.54)	4.78	0.81	.375	9.5	.126-.250	3.3-6.4	711	889
SB4-1	1/8"(.125)	#30(.129-.133)	.250	.040	.212	5.4	.032-.062	0.8-1.6	305	410
SB4-2	3.2	3.3(3.28-3.38)	6.35	1.02	.275	7.0	.063-.125	1.7-3.2	1356	1823
SB4-3					.337	8.6	.126-.187	3.3-4.8		
SB4-4					.400	10.2	.188-.250	4.9-6.4		
SB4-5					.462	11.7	.251-.312	6.5-7.9		
SB4-6					.525	13.4	.313-.375	8.0-9.5		
SB4-8					.650	16.5	.376-.500	9.6-12.7		
SB4-10					.775	19.7	.501-.625	12.8-15.9		
SB5-2	5/32"(.156)	#20(.160-.164)	.312	.050	.300	7.6	.062-.125	1.6-3.2	420	600
SB5-3	4.0	4.1(4.06-4.16)	7.92	1.27	.362	9.2	.126-.187	3.3-4.8	1868	2668
SB5-4					.425	10.8	.188-.250	4.9-6.4		
SB5-6					.550	14.0	.251-.375	6.5-9.5		
SB5-8					.675	17.2	.376-.500	9.6-12.7		
SB5-10					.800	20.3	.501-.675	12.7-17.1		
SB5-12					.925	23.5	.676-.750	17.2-19.1		
SB6-2	3/16"(.187)	#11(.192-.196)	.375	.060	.325	8.3	.062-.125	1.6-3.2	610	870
SB6-4	4.8	4.9(4.88-4.98)	9.53	1.52	.450	11.5	.126-.250	3.3-6.4	2713	3869
SB6-6					.575	14.6	.251-.375	6.5-9.5		
SB6-8					.700	17.8	.376-.500	9.6-12.7		
SB6-10					.825	21.0	.501-.625	12.8-15.9		
SB6-12					.950	24.2	.626-.750	16.0-19.1		
SB6-14					1.075	27.3	.751-.875	19.1-22.2		
SB6-16					1.200	30.5	.876-1.000	22.3-25.4		
SB8-2	1/4"(.250)	F(.257-.261)	.500	.080	.370	9.4	.062-.125	1.6-3.2	1270	1550
SB8-4	6.4	6.5(6.53-6.63)	12.70	2.03	.500	12.7	.062-.250	1.6-6.4	5649	6894
SB8-6					.625	15.9	.251-.375	6.5-9.5		
SB8-8					.750	19.1	.376-.500	9.6-12.7		
SB8-10					.875	21.0	.501-.625	12.8-15.9		
SB8-12					1.000	25.4	.626-.750	16.0-19.1		
SB8-14					1.125	28.6	.751-.875	19.1-22.2		
SB8-16					1.250	31.8	.876-1.000	22.3-25.4		
Large Flange										
SBL4-2	1/8"(.125)	#30(.129-.133)	.375	.065	.275	7.0	.032-.125	0.8-3.2	305	410
SBL4-3	3.2	3.3(3.28-3.38)	9.53	1.65	.337	8.6	.126-.187	3.3-4.8	1356	1823
SBL4-4					.400	10.2	.188-.250	4.9-6.4		
SBL4-6					.525	13.3	.251-.375	6.5-9.5		
SBL4-8					.650	16.5	.376-.500	9.6-12.7		
SBL5-4	5/32"(.156)	#20(.160-.164)	.468	.070	.425	10.8	.188-.250	4.9-6.4	420	600
SBL5-6	4.0	4.1	11.90	1.77	.550	14.0	.251-.375	6.5-9.5	1868	2668
SBL5-8					.675	17.2	.376-.500	9.6-12.7		
SBL6-4	3/16"(.187)	#11(.192-.196)	.615	.090	.450	11.5	.062-.250	1.6-6.4	610	870
SBL6-6	4.8	4.9(4.88-4.98)	15.88	2.28	.575	14.6	.251-.375	6.5-9.5	2713	3869
SBL6-8					.700	17.8	.376-.500	9.6-12.7		
SBL6-10					.825	21.0	.501-.625	12.8-15.9		
SBL6-12					.950	24.2	.626-.750	16.0-19.1		
SBL6-14					1.075	27.3	.751-.875	19.2-22.2		
SBL6-16					1.200	30.5	.876-1.000	22.3-25.4		
120° Countersunk										
SC4-2	1/8"(.125)	#30(.129-.133)	.220	.031 REF	.275	7.0	.062-.125	1.6-3.2	305	410
SC4-3	3.2	3.3(3.28-3.38)	5.59	1.14	.337	8.6	.126-.187	3.3-4.8	1356	1823
SC4-4					.400	10.2	.188-.250	4.9-6.4		
SC4-6					.525	13.3	.251-.375	6.5-9.5		
SC4-8					.650	16.5	.376-.500	9.6-12.7		
SC5-4	5/32"(.156)	#20(.160-.164)	.281	.040 REF	.425	10.8	.062-.250	1.6-6.4	420	600
	4.0	4.1	7.2	1.20					1868	2668
SC6-4	3/16"(.187)	#11(.192-.196)	.350	.050 REF	.450	11.4	.126-.250	3.3-6.4	610	870
SC6-6	4.8	4.9(4.88-4.98)	8.89	1.27	.575	14.6	.251-.375	6.5-9.5	2713	3869

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in teal green.

Aluminum Rivets



5052 Aluminum Rivet • Aluminum Mandrel • IFI Grade 11

Buttonhead

Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L Rivet Length Max. (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
AB3-2A	3/32"(.094)	#41(.097-.100)	.188	.032	.250	6.4	.032-.125	0.8-3.2	80	120
AB3-4A	2.4	2.5(2.46-2.54)	4.78	0.81	.375	9.5	.126-.250	3.3-6.4	355	533
AB4-1A	1/8"(.125)	#30(.129-.133)	.250	.040	.212	5.4	.032-.062	0.8-1.6	155	240
AB4-2A	3.2	3.3(3.28-3.38)	6.35	1.02	.275	7.0	.063-.125	1.7-3.2	689	1067
AB4-3A					.337	8.6	.126-.187	3.3-4.8		
AB4-4A					.400	10.2	.188-.250	4.9-6.4		
AB4-5A					.462	11.7	.251-.312	6.5-7.9		
AB4-6A					.525	13.4	.313-.375	8.0-9.5		
AB4-8A					.650	16.5	.376-.500	9.6-12.7		
AB4-10A					.775	19.7	.501-.625	12.8-15.9		
AB5-2A	5/32"(.156)	#20(.160-.164)	.312	.050	.300	7.6	.062-.125	1.6-3.2	230	340
AB5-3A	4.0	4.1(4.06-4.16)	7.92	1.27	.362	9.2	.126-.187	3.3-4.8	1023	1512
AB5-4A					.425	10.8	.188-.250	4.9-6.4		
AB5-6A					.550	14.0	.251-.375	6.5-9.5		
AB5-8A					.675	17.2	.376-.500	9.6-12.7		
AB5-10A					.800	20.3	.501-.625	12.7-17.1		
AB5-12A					.925	23.5	.626-.750	17.2-19.1		
AB6-2A	3/16"(.187)	#11(.192-.196)	.375	.060	.325	8.3	.062-.125	1.6-3.2	330	515
AB6-4A	4.8	4.9(4.88-4.98)	9.53	1.52	.450	11.5	.126-.250	3.3-6.4	1467	2290
AB6-6A					.575	14.6	.251-.375	6.5-9.5		
AB6-8A					.700	17.8	.376-.500	9.6-12.7		
AB6-10A					.825	21.0	.501-.625	12.8-15.9		
AB6-12A					.950	24.2	.626-.750	16.0-19.1		
AB6-14A					1.075	27.3	.751-.875	19.1-22.2		
AB6-16A					1.200	30.5	.751-1.00	19.2-25.4		
AB6-20A					1.450	36.8	1.125-1.250	28.6-31.8		
AB8-4A	1/4"(.250)	F(.257-.261)	.500	.080	.500	12.7	.062-.250	1.6-6.4	600	800
AB8-6A	6.4	6.5(6.53-6.63)	12.70	1.88	.625	15.9	.251-.375	6.5-9.5	2668	3558
AB8-8A					.750	19.1	.376-.500	9.6-12.7		
AB8-10A					.875	21.0	.501-.625	12.8-15.9		
AB8-12A					1.000	25.4	.626-.750	16.0-19.1		
AB8-14A					1.125	28.6	.751-.875	19.1-22.2		

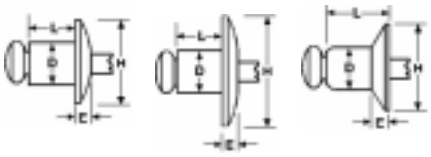
Large Flange

ABL4-2A	1/8"(.125)	#30(.129-.133)	.375	.065	.275	7.0	.032-.125	0.8-3.2	155	240
ABL4-3A	3.2	3.3(3.28-3.38)	9.53	1.14	.337	8.6	.126-.187	3.3-4.8	689	1067
ABL4-4A					.400	10.2	.188-.250	4.9-6.4		
ABL4-6A					.525	13.3	.251-.375	6.5-9.5		
ABL4-8A					.650	16.5	.376-.500	9.6-12.7		
ABL5-4A	5/32"(.156)	#20(.160-.164)	.468	.070	.425	10.8	.063-.250	1.6-6.4	230	340
	4.0	4.1(4.06-4.16)	11.9	1.20					1023	1512
ABL6-4A	3/16"(.187)	#11(.192-.196)	.615	.090	.450	11.5	.062-.250	1.6-6.4	330	515
ABL6-6A	4.8	4.9(4.88-4.98)	15.88	2.28	.575	14.6	.251-.375	6.5-9.5	1467	2290
ABL6-8A					.700	17.8	.376-.500	9.6-12.7		
ABL6-10A					.825	21.0	.501-.625	12.8-15.9		
ABL6-12A					.950	24.2	.626-.750	16.0-19.1		
ABL6-16A					1.200	30.5	.875-1.00	22.2-25.4		
ABL6-20A					1.450	36.8	1.125-1.250	28.6-31.8		

120° Countersunk

AC4-2A	1/8"(.125)	#30(.129-.133)	.220	.031 REF	.275	7.0	.062-.125	1.6-3.2	155	240
AC4-3A	3.2	3.3(3.28-3.38)	5.59	1.14	.337	8.6	.126-.187	3.3-4.8	689	1050
AC4-4A					.400	10.2	.188-.250	4.9-6.4		
AC4-6A					.525	13.3	.251-.375	6.5-9.5		
AC5-4A	5/32"(.156)	#20(.160-.164)	.281	.040 REF	.425	10.8	.188-.250	4.9-6.4	230	340
AC5-6A	4.0	4.1(4.06-4.16)	7.2	1.20	.550	14.0	.251-.375	6.5-9.5	1020	1512
AC6-4A	3/16"(.187)	#11(.192-.196)	.350	.050 REF	.407	10.3	.126-.250	3.3-6.4	330	515
AC6-6A	4.8	4.9(4.88-4.98)	8.89	1.27	.575	14.6	.251-.375	6.5-9.5	1467	2290
AC6-8A					.700	17.8	.376-.500	9.6-12.7		

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in teal green.



Aluminum/Steel Rivets

5056 Aluminum Rivet • Coated Steel Mandrel • IFI Grade 19

Buttonhead

Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L Rivet Length Max. (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Typical Ultimate Strength (Lbs.) (newtons) Tensile
AB3-2	3/32"(.094)	#41(.097-.100)	.188	.032	.250	6.4	.032-.125	0.8-3.2	120	160
AB3-4	2.4	2.5(2.46-2.54)	4.78	0.81	.375	9.5	.126-.250	3.3-6.4	534	711
AB4-1	1/8"(.125)	#30(.129-.133)	.250	.040	.212	5.4	.032-.062	0.8-1.6	225	315
AB4-2	3.2	3.3(3.28-3.38)	6.35	1.02	.275	7.0	.063-.125	1.7-3.2	1000	1401
AB4-3					.337	8.6	.126-.187	3.3-4.8		
AB4-4					.400	10.2	.188-.250	4.9-6.4		
AB4-5					.462	11.7	.251-.312	6.5-7.9		
AB4-6					.525	13.4	.313-.375	8.0-9.5		
AB4-8					.650	16.5	.376-.500	9.6-12.7		
AB4-10					.775	19.7	.501-.625	12.8-15.9		
AB5-2	5/32"(.156)	#20(.160-.164)	.312	.050	.300	7.6	.062-.125	1.6-3.2	300	470
AB5-3	4.0	4.1(4.06-4.16)	7.92	1.27	.362	9.2	.126-.187	3.3-4.8	1334	2090
AB5-4					.425	10.8	.188-.250	4.9-6.4		
AB5-6					.550	14.0	.251-.375	6.5-9.5		
AB5-8					.675	17.2	.376-.500	9.6-12.7		
AB6-2	3/16"(.187)	#11(.192-.196)	.375	.060	.325	8.3	.062-.125	1.6-3.2	465	700
AB6-4	4.8	4.9(4.88-4.98)	9.53	1.52	.450	11.5	.126-.250	3.3-6.4	2068	3113
AB6-6					.575	14.6	.251-.375	6.5-9.5		
AB6-8					.700	17.8	.376-.500	9.6-12.7		
AB6-10					.825	21.0	.501-.625	12.8-15.9		
AB6-12					.950	24.2	.626-.750	16.0-19.1		
AB6-16					1.200	30.5	.751-1.00	19.2-25.4		
AB8-4	1/4"(.250)	F(.257-.261)	.500	.080	.500	12.7	.062-.250	1.6-6.4	990	1195
AB8-6	6.4	6.5(6.53-6.63)	12.70	1.88	.625	15.9	.251-.375	6.5-9.5	4403	5315
AB8-8					.750	19.1	.376-.500	9.6-12.7		
AB8-10					.875	21.0	.501-.625	12.8-15.9		
AB8-12					1.000	25.4	.626-.750	16.0-19.1		
AB8-14					1.125	28.6	.751-.875	19.1-22.2		
AB8-16					1.250	31.8	.876-1.000	22.3-25.4		

Large Flange

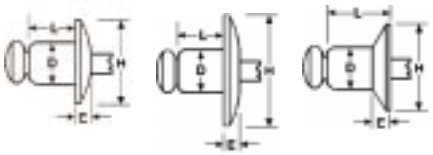
ABL4-2	1/8"(.125)	#30(.129-.133)	.375	.065	.275	7.0	.032-.125	0.8-3.2	225	315
ABL4-3	3.2	3.3(3.28-3.38)	9.53	1.65	.337	8.6	.126-.187	3.3-4.8	1000	1401
ABL4-4					.400	10.2	.188-.250	4.9-6.4		
ABL4-6					.525	13.3	.251-.375	6.5-9.5		
ABL5-4	5/32"(.156)	#20(.160-.164)	.468	.070	.425	10.8	.126-.250	3.2-6.4	300	470
	4.0	4.1(4.06-4.16)	11.9	1.78					1334	2090
ABL6-4	3/16"(.187)	#11(.192-.196)	.615	.090	.450	11.5	.062-.250	1.6-6.4	465	700
ABL6-6	4.8	4.9(4.88-4.98)	15.88	2.08	.575	14.6	.251-.375	6.5-9.5	2068	3113
ABL6-8					.700	17.8	.376-.500	9.6-12.7		
ABL6-10					.825	21.0	.501-.625	12.8-15.9		
ABL6-12					.950	24.2	.626-.750	16.0-19.1		
ABL6-14					1.075	27.3	.751-.875	19.1-22.2		
ABL6-16					1.200	30.5	.876-1.000	22.3-25.4		

120° Countersunk

AC4-2	1/8"(.125)	#30(.129-.133)	.220	.031 REF	.275	7.0	.062-.125	1.6-3.2	225	315
AC4-3	3.2	3.3 (3.28-3.38)	5.59	1.14	.337	8.6	.126-.187	3.3-4.8	1000	1401
AC4-4					.400	10.2	.188-.250	4.9-6.4		
AC4-5					.462	11.7	.251-.312	6.5-7.9		
AC5-4	5/32"(.156)	#20(.160-.164)	.281	.040 REF	.425	10.8	.188-.250	4.9-6.4	300	470
AC5-6	4.0	4.1(4.06-4.16)	7.2	1.20	.550	14.0	.251-.375	6.5-9.5	1334	2090
AC5-8					.675	17.2	.376-.500	9.6-12.7		
AC6-4	3/16"(.187)	#11(.192-.196)	.350	.050 REF	.407	10.3	.126-.250	3.3-6.4	465	700
AC6-6	4.8	4.9(4.88-4.98)	8.89	1.27	.575	14.6	.251-.375	6.5-9.5	2068	3113
AC6-8					.700	17.8	.376-.500	9.6-12.7		

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in teal green.

Stainless Rivets



Stainless Rivet • Stainless Mandrel • IFI Grade 51

Buttonhead Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No, & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L Rivet Length Max. (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
SSB4-1S	1/8"(.125)	#30(.129-.133)	.250	.040	.212	5.4	.032-.062	0.8-1.6	520	600
SSB4-2S	3.2	3.3(3.28-3.38)	6.35	1.02	.275	7.0	.063-.125	1.7-3.2	2310	2660
SSB4-3S					.337	8.6	.126-.187	3.3-4.8		
SSB4-4S					.400	10.2	.188-.250	4.9-6.4		
SSB4-5S					.462	11.7	.251-.312	6.5-7.9		
SSB4-6S					.525	13.4	.313-.375	8.0-9.5		
SSB4-8S					.650	16.5	.376-.500	9.6-12.7		
SSB5-2S	5/32"(.156)	#20(.160-.164)	.312	.045	.300	7.6	.062-.125	1.6-3.2	785	1040
SSB5-3S	4.0	4.1(4.06-4.16)	7.92	1.14	.338	8.0	.126-.187	3.2-4.8	3490	4620
SSB5-4S					.425	10.8	.188-.250	4.9-6.4		
SSB5-6S					.550	14.0	.251-.375	6.5-9.5		
SSB5-8S					.675	17.2	.376-.500	9.6-12.7		
SSB5-10S					.800	20.3	.501-.625	12.8-15.9		
SSB6-2S	3/16"(.187)	#11(.192-.196)	.375	.066	.325	8.3	.062-.125	1.6-3.2	1150	1300
SSB6-4S	4.8	4.9(4.88-4.98)	9.53	1.40	.450	11.5	.126-.250	3.3-6.4	5110	5780
SSB6-6S					.575	14.6	.251-.375	6.5-9.5		
SSB6-8S					.700	17.8	.376-.500	9.6-12.7		
SSB6-10S					.825	21.0	.501-.625	12.8-15.9		
SSB6-12S					.950	24.2	.626-.750	16.0-19.1		
SSB6-16S					1.200	30.5	.751-1.000	19.1-25.4		
SSB8-4S	1/4"(.250)	F(.257-.261)	.500	.074	.500	12.7	.062-.250	1.6-6.4	1700	2100
SSB8-6S	6.4	6.5(6.53-6.63)	12.70	1.88	.625	15.9	.251-.375	6.5-9.5	7560	9340
SSB8-8S					.750	19.1	.376-.500	9.6-12.7		
SSB8-10S					.875	21.0	.501-.625	12.8-15.9		
SSB8-12S					1.000	25.4	.626-.750	16.0-19.1		
Large Flange										
SSBL4-2S	1/8"(.125)	#30(.129-.133)	.375	.045	.275	7.0	.032-.125	0.8-3.2	520	600
SSBL4-3S	3.2	3.3(3.28-3.38)	9.53	1.14	.337	8.6	.126-.187	3.3-4.8	2310	2660
SSBL4-4S					.400	10.2	.188-.250	4.9-6.4		
SSBL6-4S	3/16"(.187)	#11(.192-.196)	.615	.082	.450	11.5	.062-.250	1.6-6.4	1150	1300
SSBL6-6S	4.8	4.9(4.88-4.98)	15.88	2.08	.575	14.6	.251-.375	6.5-9.5	5110	5780
SSBL6-8S					.700	17.8	.376-.500	9.6-12.7		
SSBL6-10S					.825	21.0	.501-.625	12.8-15.9		
SSBL6-12S					.950	24.2	.626-.750	16.0-19.1		
120° Countersunk										
SSC4-2S	1/8"(.125)	#30(.129-.133)	.220	.045	.275	7.0	.063-.125	1.7-3.2	520	600
SSC4-3S	3.2	3.3(3.28-3.38)	5.59	1.14	.337	8.6	.126-.187	3.3-4.8	2310	2660
SSC4-4S					.400	10.2	.188-.250	4.9-6.4		
SSC4-5S					.462	11.7	.251-.312	6.5-7.9		
SSC6-4S	3/16"(.187)	#11(.192-.196)	.350	.050	.407	10.3	.126-.250	3.3-6.4	1150	1300
	4.8	4.9(4.88-4.98)	8.89	1.27					5110	5780

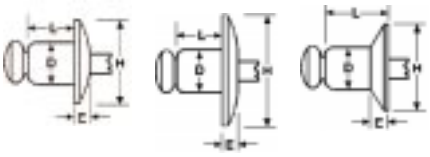
KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in teal green.

Meet our stainless lineup

Standard

Countersink

Closed-End



Stainless/Steel Rivets

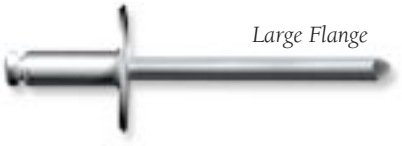
Stainless Rivet • Coated Steel Mandrel • IFI Grade 50

Buttonhead Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
SSB4-1	1/8"(.125)	#30(.129-.133)	.250	.040	.212	5.4	.032-.062	0.8-1.6	520	600
SSB4-2	3.2	3.3(3.28-3.38)	6.35	1.02	.275	7.0	.063-.125	1.7-3.2	2310	2660
SSB4-3					.337	8.6	.126-.187	3.3-4.8		
SSB4-4					.400	10.2	.188-.250	4.9-6.4		
SSB4-5					.462	11.7	.251-.312	6.5-7.9		
SSB4-6					.525	13.4	.313-.375	8.0-9.5		
SSB4-8					.650	16.5	.376-.500	9.6-12.7		
SSB5-2	5/32"(.156)	#20(.160-.164)	.312	.045	.300	7.6	.062-.125	1.6-3.2	785	1040
SSB5-4	4.0	4.1(4.06-4.16)	7.92	1.14	.425	10.8	.126-.250	4.9-6.4	3490	4620
SSB5-6					.550	14.0	.251-.375	6.5-9.5		
SSB6-2	3/16"(.187)	#11(.192-.196)	.375	.055	.325	8.3	.062-.125	1.6-3.2	1150	1300
SSB6-4	4.8	4.9(4.88-4.98)	9.53	1.40	.450	11.5	.126-.250	3.3-6.4	5110	5780
SSB6-6					.575	14.6	.251-.375	6.5-9.5		
SSB6-8					.700	17.8	.376-.500	9.6-12.7		
SSB6-10					.825	21.0	.501-.625	12.8-15.9		
SSB6-12					.950	24.2	.626-.750	16.0-19.1		
SSB6-16					1.120	30.5	.751-1.000	19.2-25.4		
Large Flange										
SSBL4-2	1/8"(.125)	#30(.129-.133)	.375	.045	.275	7.0	.032-.125	0.8-3.2	520	600
SSBL4-3	3.2	3.3(3.28-3.38)	9.53	1.14	.337	8.6	.126-.187	3.3-4.8	2310	2660
SSBL4-4					.400	10.2	.188-.250	4.9-6.4		
SSBL6-4	3/16"(.187)	#11(.192-.196)	.625	.082	.450	11.5	.062-.250	1.6-6.4	1150	1300
SSBL6-6	4.8	4.9(4.88-4.98)	15.88	2.08	.575	14.6	.251-.375	6.5-9.5	5110	5780
SSBL6-8					.700	17.8	.376-.500	9.6-12.7		
SSBL6-10					.825	21.0	.501-.625	12.8-15.9		
SSBL6-12					.950	24.2	.626-.750	16.0-19.1		
120° Countersunk										
SSC4-2	1/8"(.125)	#30(.129-.133)	.220	.045	.275	7.0	.063-.125	1.7-3.2	520	600
SSC4-3	3.2	3.3(3.28-3.38)	5.59	1.14	.337	8.6	.126-.187	3.3-4.8	2310	2660
SSC4-4					.400	10.2	.188-.250	4.9-6.4		
SSC4-5					.462	11.7	.251-.312	6.5-7.9		
SSC6-4	3/16"(.187)	#11(.192-.196)	.350	.050	.407	10.3	.126-.250	3.3-6.4	1150	1300
	4.8	4.9(4.88-4.98)	8.89	1.27					5110	5780

KLIK-FAST RIVETS conform to IFI-114 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in teal green.

KLIK-FAST® stainless steel rivets from Marson Corporation provide outstanding value and offer your assemblies:

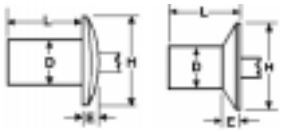
- Corrosion resistance
- Multiple head styles
- High strength
- Widest size range ⅛"– ¼"



Large Flange

Whether the application is marine, medical or electronics, for long life of the assembly, count on Marson. All Marson rivets conform to IFI specifications. Call today for more information on our entire line of high quality rivets and fastening tools.

Closed-End Rivets



5056 Aluminum/Steel Buttonhead • IFI Grade 19

Marson Part No.	D Rivet Dia. Nom. Inch	Drill No. & Hole Size	H Head Dia. Nom. Inch	E Head Height Max. Inch	L Rivet Length Max. Inch	L Rivet Length Max. (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) Shear	Typical Ultimate Strength (Lbs.) Tensile
AB4-1C	1/8"(.126)	#30	.236	.050	.296	7.52	.032-.062	0.8-1.6	240	280
AB4-2C	3.2	(.129-.133)			.355	9.02	.063-.125	1.7-3.2	1060	1240
AB4-3C					.414	10.52	.126-.187	3.3-4.8		
AB4-4C					.473	11.10	.188-.250	4.9-6.4		
AB4-5C					.532	13.51	.251-.312	6.5-7.9		
AB4-6C					.591	15.06	.313-.375	8.0-9.5		
AB5-2C	5/32"(.157)	#20	.315	.065	.355	9.02	.063-.125	1.7-3.2	350	480
AB5-3C	4.0	(.160-.164)			.414	10.52	.126-.187	3.3-4.8	1550	2130
AB5-5C					.532	13.51	.188-.312	4.9-7.9		
AB6-2C	3/16"(.188)	#11	.374	.080	.355	9.02	.063-.125	1.7-3.2	500	690
AB6-4C	4.8	(.192-.196)			.473	11.10	.126-.250	3.3-6.4	2230	3070
AB6-6C					.591	15.06	.251-.375	6.5-9.5		
AB6-8C					.748	19.00	.376-.500	9.6-12.7		
AB6-10C					.866	22.00	.501-.625	12.8-15.9		
AB8-4C	1/4"(.252)	F	.512	.090	.532	13.51	.062-.250	1.6-6.4	900	1100
AB8-6C	6.4	(.257-.261)			.670	17.02	.251-.375	6.5-9.5	3950	5000

120° Countersunk

AC4-2C	1/8"(.126)	#30	.236	.050	.355	9.02	.063-.125	1.7-3.2	240	280
AC4-3C	3.2	(.129-.133)			.414	10.52	.126-.187	3.3-4.8	1060	1240
AC4-4C					.473	11.10	.188-.250	4.9-6.4		
AC6-4C	3/16"(.188)	#11	.374	.065	.473	11.10	.126-.250	3.3-6.4	500	690
	4.8	(.192-.196)							2230	3070

All Aluminum • IFI Grade 15

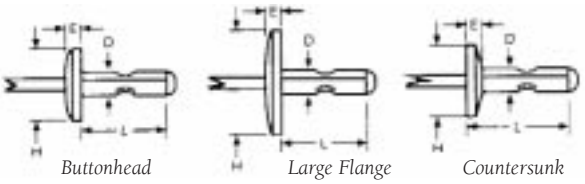
AB4-2AC	1/8"(.126)	#30	.236	.050	.355	9.02	.063-.125	1.7-3.2	99	108
AB4-3AC	3.2	(.129-.133)			.414	10.52	.126-.187	3.3-4.8	450	490
AB4-4AC					.473	11.10	.188-.250	4.9-6.4		
AB5-4AC	5/32"(.157)	#20	.315	.065	.473	11.10	.126-.250	3.3-6.4	127	180
	4.0	(.160-.164)							580	820
AB6-2AC	3/16"(.188)	#11	.374	.080	.355	9.02	.063-.125	1.7-3.2	198	246
AB6-4AC	4.8	(.192-.196)			.473	11.10	.126-.250	3.3-6.4	900	1120
AB6-6AC					.591	15.06	.251-.375	6.5-9.5		
AB6-8AC					.748	19.00	.376-.500	9.6-12.7		
AB6-10AC					.866	22.00	.501-.625	12.8-15.9		

All Stainless

SSB4-2S	1/8"(.126)	#30	.236	.039	.355	9.02	.063-.125	1.7-3.2	441	551
SSB4-3S	3.2	(.129-.133)	5.99	.990	.414	10.52	.126-.187	3.3-4.8	2000	2500
SSB4-4S					.473	11.10	.188-.250	4.9-6.4		
SSB6-2S	3/16"(.188)	#11	.374	.070	.355	9.02	.063-.125	1.7-3.2	991	1210
SSB6-4S	4.8	(.192-.196)	9.49	1.77	.473	11.10	.126-.250	3.3-6.4	4500	5500
SSB6-6S					.591	15.06	.251-.375	6.5-9.5		
SSB6-8S					.748	19.00	.376-.500	9.6-12.7		
SSB6-10S					.866	22.00	.501-.625	12.8-15.9		

Note: A slightly smaller mandrel diameter is required for closed-end rivets; therefore when setting closed-end rivets using Marson rivet setting tools, we recommend you use one size smaller nosepiece when possible (i.e., to set 1/8" rivets, use 3/32" nosepiece).

KLIK-FAST RIVETS conform to IFI-126 (inch). Millimeters (mm) and newtons (N) are in teal green.



Buttonhead *Large Flange* *Countersunk*

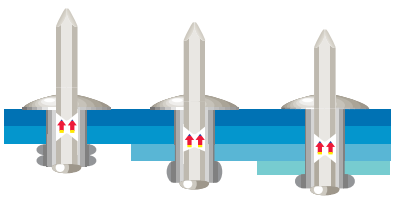
Multi-Grip Rivets

Plated Steel Rivet • Plated Steel Mandrel* • IFI Grade 30

Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
Steel Buttonhead										
SB41-42MG	1/8"(.125)	#30(.129-.133)	.283	.033	.355	9.0	.043-.156	1.1-4.0	340	385
	3.2	3.3(3.28-3.38)	7.2	0.85					1510	1710
SB52-53MG	5/32"(.156)	#20(.160-.164)	.319	.047	.433	11.0	.056-.196	1.4-5.0	440	530
	4.0	4.1(4.06-4.16)	8.1	1.20					1960	2360
SB62-63MG	3/16"(.187)	#11(.192-.196)	.386	.069	.405	10.3	.047-.187	1.2-4.8	810	750
	4.8	4.9(4.88-4.98)	9.8	1.75					3605	3335
SB63-64MG					.500	12.7	.156-.250	4.0-6.3	1025	780
									4560	3470
Aluminum/Steel Buttonhead†										
AB41-43MG	1/8"(.125)	#30(.129-.133)	.250	.037	.315	8.0	.031-.187	0.8-4.8	165	230
AB42-44MG	3.2	3.3(3.28-3.38)	6.35	0.95	.375	9.5	.046-.250	1.2-6.4	735	1025
AB44-45MG					.438	11.1	.156-.312	4.0-7.9		
AB45-46MG					.500	12.7	.216-.375	5.5-9.5		
AB52-54MG	5/32"(.156)	#20(.160-.164)	.312	.047	.375	9.5	.046-.250	1.2-6.4	255	375
AB54-56MG	4.0	4.1(4.06-4.16)	7.92	1.20	.500	12.7	.156-.375	4.0-9.5	1135	1670
AB56-58MG					.666	16.9	.250-.500	6.4-12.7		
AB62-64MG	3/16"(.187)	#11(.192-.196)	.386	.057	.406	10.3	.062-.250	1.6-6.4	350	530
AB63-67MG	4.8	4.9(4.88-4.98)	9.8	1.45	.595	15.1	.187-.437	4.8-11.1	1560	2360
AB66-68MG					.666	16.9	.250-.500	6.4-12.7		
AB610-612MG					.978	24.8	.500-.781	12.7-19.8		
Aluminum/Steel Large Flange										
ABL42-43MG	1/8"(.125)	#30(.129-.133)	.325	.039	.315	8.0	.031-.187	0.8-4.8	165	230
ABL42-44MG	3.2	3.3(3.28-3.38)	8.25	1.00	.375	9.5	.046-.250	1.2-6.4	735	1025
ABL44-45MG					.438	11.1	.156-.312	4.0-7.9		
ABL52-54MG	5/32"(.156)	#20(.160-.164)	.374	.051	.375	9.5	.062-.250	1.6-6.4	255	375
ABL53-55MG	4.0	4.1(4.06-4.16)	9.5	1.30	.438	11.1	.125-.312	3.2-7.9	1135	1670
ABL55-58MG					.690	17.5	.251-.500	6.4-12.7		
ABL62-64MG	3/16"(.187)	#11(.192-.196)	.625	.069	.406	10.3	.062-.250	1.6-6.4	350	530
ABL66-68MG	4.8	4.9(4.88-4.98)	15.85	1.75	.666	16.9	.250-.500	6.4-12.7	1560	2360
ABL610-612MG					.978	24.8	.500-.781	12.7-19.8		
Aluminum/Steel 120° Countersunk										
AC43-44MG	1/8"(.125)	#30(.129-.133)	.209	.029	.383‡	9.7	.093-.250	2.4-6.4	155	206
	3.2	3.3(3.28-3.38)	5.3	0.75					690	912
AC53-55MG	5/32"(.156)	#20(.160-.164)	.252	.049	.470‡	11.9	.109-.312	2.7-7.9	255	300
	4.0	4.1(4.06-4.16)	6.40	1.24					1135	1670
AC62-65MG	3/16"(.187)	#11(.192-.196)	.345	.051	.500‡	12.7	.062-.312	1.6-7.9	350	530
AC66-68MG	4.8	4.9(4.88-4.98)	8.75	1.30	.690‡	17.5	.250-.500	6.4-12.7	1560	2360

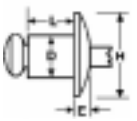
** Mandrel–Clear Passivate* *† Mandrel–Zinc with Yellow Dichromate Finish* *‡ C.S.K.–Total Length (L) including head*

Millimeters (mm) and newtons (N) are in teal green.



Multi-grip rivets provide an effective and economical alternative to other, more costly methods of fastening, because one size handles the grip range capacity of up to 3 standard open end rivets. Multi-grip rivets can be used in any application requiring open end rivets, while reducing inventory requirements. Use multi-grip rivets as a standard open-end rivet... no special tool is needed.

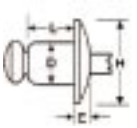
Copper/Brass Rivets



#110 Copper Rivet • Brass Mandrel IFI Grade 20

Marson Part No.	D Rivet Dia. Nom. Inch	Drill No, & Hole Size	H Head Dia. Nom. Inch	E Head Height Max. Inch	L Rivet Length Max. Inch		Grip Range Inch		Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
CB4-2B	1/8"(.125)	#30(.129-.133)	.125	.040	.275	7.0	.063-.125	1.7-3.2	215	300
CB4-4B	3.2	3.3(3.28-3.38)	6.35	1.02	.400	10.2	.188-.250	4.9-6.4	950	1330

Copper/Steel Rivets



#110 Copper Rivet • Copper-Plated Steel Mandrel IFI Grade 20

CB4-2C	1/8"(.125)	#30(.129-.133)	.125	.040	.275	7.0	.063-.125	1.7-3.2	215	300
CB4-4C	3.2	3.3(3.28-3.38)	6.35	1.02	.400	10.2	.188-.250	4.9-6.4	950	1330

Painted Rivets*

W=White BR=Brown BL=Black

Marson Part No.	Rivet Color	D Rivet Dia. Norm. Inch	Drill No.& Hole Size	H Head Dia. Norm.Inch	E Head Height Max. Inch	L Rivet Length Max. Inch	(mm)	Grip Range Inch	(mm)	Typical Ultimate Strength (lbs.) (newtons) Shear	Tensile
AB4-2AW	W	1/8" (.125)	#30 (.129-.133)	.125	.040	.275	7.0	.062-.125	1.7-3.2	155	240
AB4-3AW	W	3.2	3.3(3.28-3.38)	6.35	1.02	.337	8.6	.126-.187	3.2-4.8	689	1067
AB4-4AW	W					.400	10.2	.188-.250	4.9-6.4		
AB4-2ABR	BR	1/8" (.125)	#30 (.129-.133)	.125	.040	.275	7.0	.062-.125	1.7-3.2	155	240
AB4-3ABR	BR	3.2	3.3(3.28-3.38)	6.35	1.02	.337	8.6	.126-.187	3.2-4.8	689	1067
AB4-4ABR	BR					.400	10.2	.188-.250	4.9-6.4		
AB4-2ABL	BL	1/8" (.125)	#30 (.129-.133)	.125	.040	.275	7.0	.062-.125	1.7-3.2	155	240
AB4-3ABL	BL	3.2	3.3(3.28-3.38)	6.35	1.02	.337	8.6	.126-.187	3.2-4.8	689	1067
AB4-4ABL	BL					.400	10.2	.188-.250	4.9-6.4		
SB4-2W	W	1/8" (.125)	#30 (.129-.133)	.125	.040	.275	7.0	.062-.125	1.7-3.2	305	410
SB4-3W	W	3.2	3.3(3.28-3.38)	6.35	1.02	.337	8.6	.126-.187	3.2-4.8	1356	1823
SB4-4W	W					.400	10.2	.188-.250	4.9-6.4		
SB4-2BR	BR	1/8" (.125)	#30 (.129-.133)	.125	.040	.275	7.0	.062-.125	1.7-3.2	305	410
SB4-3BR	BR	3.2	3.3(3.28-3.38)	6.35	1.02	.337	8.6	.126-.187	3.2-4.8	1356	1823
SB4-4BR	BR					.400	10.2	.188-.250	4.9-6.4		
SB4-2BL	BL	1/8" (.125)	#30 (.129-.133)	.125	.040	.275	7.0	.062-.125	1.7-3.2	330	515
SB4-4BL	BL	3.2	3.3(3.28-3.38)	6.35	1.02	.400	10.2	.188-.250	4.9-6.4	1467	2290
AB6-4AW	W	3/16" (.187)	#11(.192-.196)	.375	.060	.450	11.5	.126-.250	3.2-6.4	330	515
AB6-4ABL	BL	4.8	4.9(4.88-4.98)	9.53	1.52	.450	11.5	.126-.250	3.2-6.4	1467	2290

** Custom colors available; contact factory for additional information.*

Back-Up Washers

Marson Part No.	Bulk Part No.	500 Pack No.	Standard Carton Qty.	Material	For Hole Size	Size/Shape
SS-3	50653	40653	5M	STEEL	3/32"	1/2" SQ
SS-4	50654	40654	5M	STEEL	1/8"	1/2" SQ
SS-6	50656	40656	5M	STEEL	3/16"	1/2" SQ
SS-8	50658	40658	10M	STEEL	1/8"	3/8" RD
SS-9	50655	40655	10M	STEEL	5/32"	7/16" RD
SS-10	50661	40661	10M	STEEL	3/16"	1/2" RD
SS-12	50662	40662	10M	STEEL	1/4"	1/2" RD
AS-8	50657	40657	10M	ALUMINUM	1/8"	3/8" RD
AS-9	50659	40659	10M	ALUMINUM	5/32"	7/16" RD
AS-10	50660	40660	10M	ALUMINUM	3/16"	1/2" RD
AS-12	50665	40665	10M	ALUMINUM	1/4"	1/2" RD

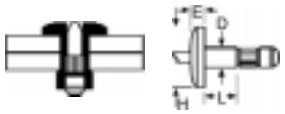
Back-up washers are .056"-.062" thick. They are used when fastening soft materials or to compensate for oversize holes where access to both sides of the work is possible.

Double-Ended Drill Bit/39100

This double-ended drill bit provides the correct size hole and angle for 1/8" diameter countersink rivets, drilling and countersinking in one operation.

Steel Q-Lok™ Rivets

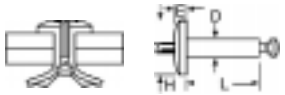
Plated Steel Body Plated Steel Mandrel



Marson Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch	L (mm)	Grip Range Inch	Grip Range (mm)	Typical Ultimate Strength (Lbs.) (newtons) Shear	Tensile
SB4-2QL	1/8"(.125)	#30(.129-.133)	.250	.045	.300	7.6	.062-.125	1.6-3.2	500	400
SB4-4QL	3.2	3.3(3.28-3.38)	6.40	1.20	.425	10.8	.126-.250	3.3-6.4	2220	1780
SB5-2QL	5/32"(.156)	#20(.160-.164)	.312	.055	.325	8.3	.062-.125	1.6-3.2	700	550
SB5-4QL	4.0	4.1(4.06-4.16)	7.9	1.40	.450	11.4	.126-.250	3.3-6.4	3110	2440
SB6-2QL	3/16"(.187)	#11(.192-.196)	.375	.065	.350	8.9	.062-.125	1.6-3.2	1050	825
SB6-4QL	4.8	4.9(4.88-4.98)	9.5	1.65	.475	12.0	.126-.250	3.3-6.4	4670	3670
SB6-6QL					.600	15.2	.251-.375	6.5-9.5		
SB6-8QL					.725	18.4	.376-.500	9.6-12.7		

T-Rivets/Klik-Split®

Aluminum/Steel†



52372	1/4"(.250)	F(.257-.261)	.500	.120	.520	13.22	.062-.125	1.58-3.18	1500	1000
52371	6.4	6.5(.653-6.63)	12.7	3.00	.520	13.22	.032-.140	0.81-3.56	6670	4445
52368					.707	17.79	.251-.312	6.38-7.93		
52369					.770	19.56	.312-.375	7.95-9.53		
52370					.832	21.13	.376-.437	9.55-11.10		
50376					.960	24.38	.520-.620	13.21-15.97		

† Requires nosepiece No. 96028 when using the Marson Big Daddy® (39031) hand tool.

KLIK-FAST RIVETS conform to IFI-130 (inch) and IFI-505 (metric). Millimeters (mm) and newtons (N) are in teal green.

Automotive/Special Application Rivets

Trim Rivets

Marson Part No.	Description	Grip Range	Materials Body/Mandrel	Rivet Dia. Nom.	Flange Dia. Nom.	Hole Dia. Range	500 Pack No.	Applications
50261*	Trim Moulding Rivet	.126-.187	Alum/Alum	.125	.208	.129-.133	40261	(ABN4-3A)
50262*	Long Trim Moulding Rivet	.188-.250	Alum/Alum	.125	.208	.129-.133	40262	(ABN4-4A)
50516*	Trim Moulding Rivet w/SS Body	.126-.187	SS/Steel	.125	.208	.129-.133	40516	(SSBN4-3)

**Use 39112 Trim Clip Rivet Nosepieces with HP-2 or Kliker Riveter to form trim clip studs with 50261; 50262; 50516 rivets.*

Klik-Split® Window & Door Rivets†

52371	Window Regulator Rivet	.032-.140	Alum/Steel	.250	.500	.257-.261	NA	GM 9436175 Ford 385189 Chry 6031115
52372	Outside Door Handle Rivet with recessed head	.090-.115	Alum/Steel	.250	.500	.257-.261	NA	Ford 388047-S100
52373	Door Handle Rivet w/recessed head and zinc coated mandrel	.110-.177	Alum/Steel	.250	.500	.257-.261	NA	GM 20713843
52374	Window Regulator Rivet w/yellow zinc coated mandrel	.140-.187	Alum/Steel	.250	.500	.257-.261	NA	GM 9437486 Chry 6032926
52375	Blk. Anodized Door Handle Rivet	.090-.115	Alum/Steel	.250	.500	.257-.261	NA	Ford 388047-S102
50376	Glass Stop Rivet	.520-.620	Alum/Steel	.250	.500	.257-.261	NA	Ford 385323 Chry 6031091

† Requires nosepiece No. 96028 when using the Marson Big Daddy® (39031) hand tool.

Bumper Rivets

53150	Bumper Fascia Rivet large flange black	.250-.375	Steel/Steel	.187	.625	.192-.196	NA	GM 9439719
53181	Bumper Fascia Rivet w/yellow zinc coated mandrel	.125-.250	Steel/Steel	.250	.500	.257-.261	NA	Ford 372820-S36

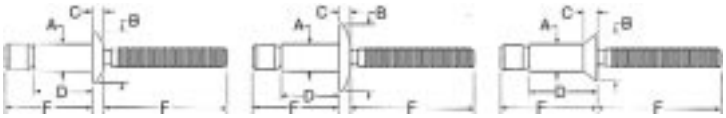
Miscellaneous Rivets

53295	Rear Window Gasket Rivet	.125-.187	Alum/Steel	.125	.325	.129-.130	NA	GM 20325696
53314	Multi-Purpose Rivet, large flange	.125-.187	Alum/Steel	.125	.375	.129-.130	NA	GM 9432552
53353	Trunk Lock Swivel Emblem Rivet sealed end, countersunk head Requires Nosepiece #39144	.126-.187	Alum/Steel	.156	.312	.160-.164	NA	GM 9432137 Chry 6032138

Klik-Lock™ Rivets

Marson Part No.	A Rivet Dia. Inch (mm)	Required Hole Size Inch (mm)	B Head Dia. Inch (mm)	C Head Height Max. Inch (mm)	D Body Length Max. Inch (mm)	E Overall Length Max. (mm)	F Length Max. Inch (mm)	Grip Range Inch (mm)	Average Shear Strength lbs. (newtons)	Average Tensile Strength lbs. (newtons)
Steel Rivet • Steel Mandrel • Buttonhead										
SB6-4KL	.188	.191-.201	.385	.085	.415	.675	1.00	.062-.270	1450	1200
	4.8	4.9-5.10	9.77	2.15	10.45	15.87	25.40	1.57-6.85	6499	5379
SB6-7KL					.572	.825	1.00	.214-.437		
					14.52	20.95	25.40	5.43-11.09		
SB6-EKL					.572	.950	1.00	.062-.437		
					14.52	24.13	25.40	1.57-11.09		
SB8-6KL	.257	.261-.272	.525	.117	.560	.970	1.00	.080-.375	2750	2200
	6.5	6.6-6.9	13.33	2.97	14.62	24.63	25.40	2.03-9.52	12326	9861
SB8-10KL					.810	1.220	1.00	.350-.625		
					20.57	30.98	25.40	8.89-15.75		
SB8-EKL					.810	1.405	1.00	.080-.625		
					20.57	35.68	25.40	2.03-15.87		
Large Flange										
SBL6-4KL	.188	.191-.201	.500	.085	.415	.675	1.00	.062-.270	1450	1200
	4.8	4.9-5.1	12.70	2.15	10.45	15.87	25.40	1.57-6.85	6499	5379
SBL6-EKL					.572	950	1.00	.062-.437		
					14.52	24.13	25.40	1.57-11.09		
SBL8-6KL	.257	.261-.272	.588	.117	.560	.970	1.00	.080-.375	2750	2200
	6.5	6.6-6.9	14.93	2.97	14.62	24.63	25.40	2.03-9.52	12326	9861
100° Countersunk										
SC6-6KL	.188	.191-.201	.345	.070	.486	.762	1.00	.125-.331	1450	1200
	4.8	4.9-5.1	8.8	1.8	12.34	19.35	25.40	3.17-8.40	6499	5379
SC6-9KL					.653	.929	1.00	.305-.500		
					16.58	23.59	25.40	7.74-12.70		
SC8-8KL	.257	.261-.272	.405	.079	.660	1.059	1.00	.160-.475	2750	2200
	6.5	6.6-6.9	10.3	2.0	16.76	26.89	25.40	4.06-12.06	12326	9861
SC8-12KL					.910	1.309	1.00	.415-.725		
					23.11	33.24	25.40	10.54-18.41		
Aluminum Rivet • Aluminum Mandrel • Buttonhead										
AB6-4AKL	.188	.191-.201	.385	.085	0.415	.675	1.00	.062-.270	700	500
	4.8	4.9-5.1	9.8	2.15	10.54	15.87	25.40	1.57-6.85	3138	2241
AB6-7AKL					.572	.825	1.00	.214-.437		
					14.52	20.95	25.40	5.43-11.09		
AB6-AEKL					.572	950	1.00	.062-.437		
					14.52	24.13	25.40	1.57-11.09		
AB8-6AKL	.257	.261-.272	.525	.117	.560	.970	1.00	.080-.375	1300	890
	6.5	6.6-6.9	13.33	2.97	14.62	24.63	25.40	2.03-9.52	5827	3989
AB8-10AKL					.810	1.220	1.00	.350-.625		
					20.57	30.98	25.40	8.89-15.87		
AB8-AEKL					.810	1.405	1.00	.080-.625		
					20.57	35.56	25.40	2.03-15.87		
Large Flange										
ABL6-4AKL	.188	.191-.201	.500	.085	.415	.675	1.00	.062-.270	700	500
	4.8	4.9-5.1	12.7	2.15	10.45	15.87	25.40	1.57-6.85	3138	2241
ABL6-7AKL					.572	.825	1.00	.214-.437		
					14.52	20.95	25.40	5.43-11.09		
100° Countersunk										
AC6-6AKL	.188	.191-.201	.345	.070	.486	.762	1.00	.125-.331	700	500
	4.8	4.9-5.1	8.8	1.8	12.34	19.35	25.40	3.17-8.40	3138	2241
AC6-9AKL					.653	.929	1.00	.305-.500		
					16.58	23.59	25.40	7.74-12.70		
AC8-8AKL	.257	.261-.272	.405	.079	.660	1.059	1.00	.160-.475	1300	890
	6.5	6.6-6.9	10.3	2.0	16.76	26.89	25.40	4.06-12.06	5827	3989
AC8-12AKL					.910	1.309	1.00	.415-.725		
					23.11	33.24	25.40	10.54-18.41		

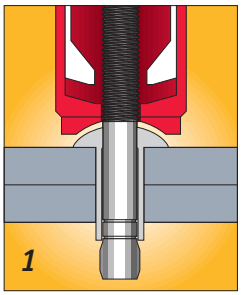
Note: All yellow shaded items are special order only; minimums apply.



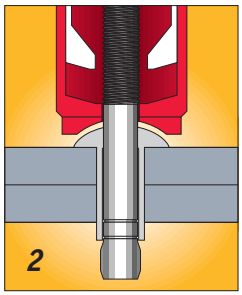
Klik-Lock™ Rivets

Marson Part No.	A Rivet Dia. Inch (mm)	Required Hole Size Inch (mm)	B Head Dia. Inch (mm)	C Head Height Max. Inch (mm)	D Body Length Max. Inch (mm)	E Overall Length Max. (mm)	F Length Max. Inch (mm)	Grip Range Inch (mm)	Average Shear Strength lbs. (newtons)	Average Tensile Strength lbs. (newtons)
Stainless Rivet • Stainless Mandrel • Buttonhead										
SSB6-4SKL	.188	.191-.201	.385	.085	.415	.625	1.00	.062-.270	1400	1000
	4.8	4.9-5.1	9.8	2.15	10.54	17.14	25.40	1.57-6.85	6275	4482
SSB6-7SKL					.572	.825	1.00	.214-.437		
					14.52	20.95	25.40	5.43-11.09		
SSB6-ESKL					.572	.950	1.00	.062-.437		
					14.52	24.13	25.40	1.57-11.09		
SSB8-6SKL	.257	.261-.272	.525	.117	.560	.970	1.00	.080-.375	2500	2000
	6.5	6.6-6.9	13.3	2.97	14.62	24.63	25.40	2.03-9.52	11206	8964
SSB8-10SKL					.810	1.220	1.00	.350-.625		
					20.57	30.98	25.40	8.89-15.87	.	.
100° Countersunk										
SSC6-6SKL	.188	.191-.201	.345	.070	.486	.762	1.00	.125-.331	1400	1000
	4.8	4.9-5.1	8.8	1.8	12.34	19.35	25.40	3.17-8.40	6275	4482
SSC8-8SKL	.257	.261-.272	.405	.079	.560	1.059	1.00	.160-.475	2500	2000
	6.5	6.6-6.9	10.3	2.0	14.62	26.89	25.40	4.06-12.06	11206	8964

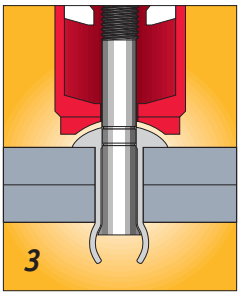
Millimeters (mm) and newtons (n) are in teal.



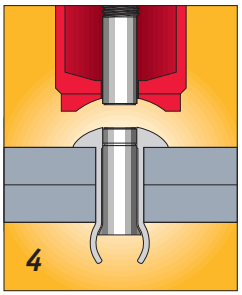
1 After drilling hole to proper diameter, rivet is placed into hole and rivet setting tool is placed over mandrel.



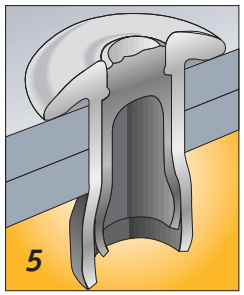
2 Actuating tool starts mandrel into rivet body, pulling work material together and expanding body on the blind side.



3 A solid circle lock is created between the body and mandrel creating a weather resistant assembly that virtually eliminates pin pushout.



4 After the mandrel is broken, the mandrel is flush with the rivet body removing the need for grinding.



5 The expansion of the body tightly fills the hole creating a weather-resistant joint, and the flush break eliminates the need for grinding.

Material and Finish

Material	Sleeve	Pin	Sleeve Finish	Pin Finish
Steel	Low	Medium	Zinc Plated	Zinc Plated
	Carbon Steel	Carbon Steel	Clear Chromate	Gold Chromate
Aluminum	5056	7075	Clear Chromate	Gold Chromate
Stainless	302	305/304	Passivated	Dry Lubricated

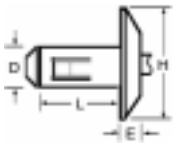
Pin Retention Values (lbs.)

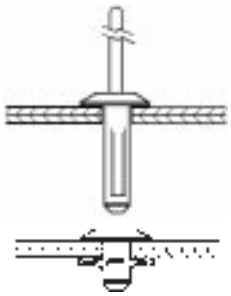
		Steel	Aluminum	Stainless Steel
3/16"	Pin Retention	300	50	125
1/4"	Pin Retention	500	100	250

Equivalent to Monobolt®, TigerBolt®, Magna Lok®, Ultra-Grip® and Mega-Grip®.

When setting Marson Klik-Lock rivets, no special nosepiece is required.

Plastic Rivets





Plastic rivet before and after set.

Klik-Lok Plastic Rivets

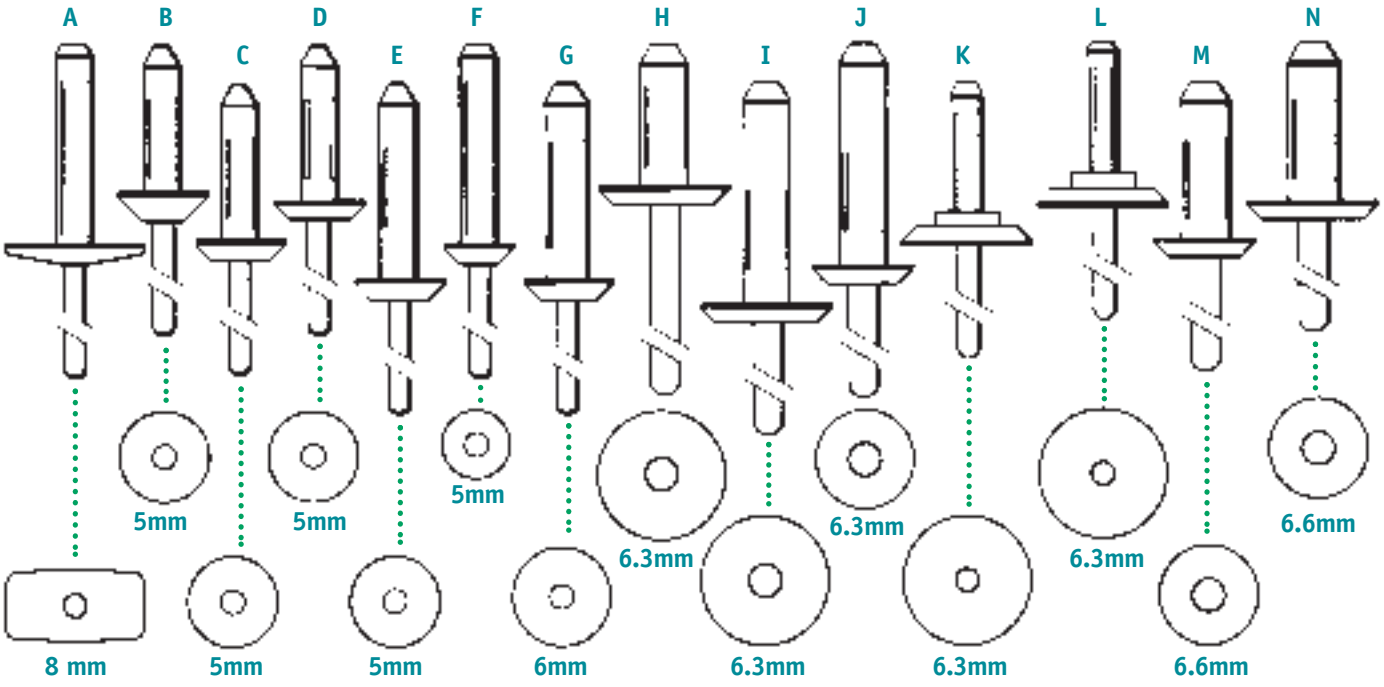
Marson Corporation Klik-Lok Plastic Rivets are the same precision-molded all-nylon rivets used by domestic auto manufacturers, both for original equipment and replacement parts. In addition, Klik-Lok Plastic Rivets are ideal for non-conductive and non-corrosive environments. Klik-Lok Plastic Rivets fasten plastic to plastic, plastic to metal and plastic to fiberglass. As they set, three "legs" form to securely lock the components in place and prevent pullout.

Diagram Reference	100-Pack Part No.*	D Rivet Dia. Nom. Inch	Hole Size Inch	Hole Size (mm)	H Head Dia. Nom. Inch	E Head Height Max. Inch	L Rivet Length Max. Inch	Grip Range Inch	Typical Ultimate Strength (Lbs.) Shear	Tensile
A	48286	.154	.156	(4)	.315	.098	1.024	.236 - .413	40	82
B	48305	.195	.197	(5)	.472	.130	.728	.059 - .177	68	120
C	48306	.195	.197	(5)	.472	.071	.787	.118 - .236	68	120
D	48307	.195	.197	(5)	.472	.071	.787	.118 - .177	68	120
E	48308	.195	.197	(5)	.472	.071	.984	.236 - .394	68	120
F	48309	.195	.197	(5)	.354	.071	.650	.118 - .157	68	120
G	48330	.234	.236	(6.0)	.512	.098	1.102	.157 - .335	110	181
H	48349	.246	.250	(6.3)	.669	.098	.709	.157 - .236	121	194
I	48350	.246	.250	(6.3)	.669	.098	1.102	.157 - .394	121	194
J	48351	.246	.250	(6.3)	.512	.098	1.102	.157 - .394	121	194
K	48353	.246	.250	(6.3)	.670	.098	.682	.028 - .193	121	194
L	48354	.246	.250	(6.3)	.670	.098	.682	.028 - .178	121	194
M	48385	.258	.260	(6.6)	.512	.098	.787	.098 - .197	137	219
N	48386	.258	.260	(6.6)	.709	.098	.787	.098 - .197	137	219

* Also available in bulk 2,000/ctn and visual boxes, 20/pkg.

Actual Size Rivets/Flanges

When ordering, match diagram reference letter with those in above chart.



Plastic Rivet Tools

Klik-Lok™ Plastic Rivet Setter/48000

This plastic rivet setter delivers the extra-long pulling stroke needed to set plastic rivets. Its all-steel construction and full-size handles make for smooth easy operation. The tool is packaged in a reusable, heavy-duty vinyl pouch. Weight: .6 lb.

Klik-Lok™ Plastic Rivet Kit/48001

You'll be all set for the next job that requires plastic rivet fastening with this kit. The kit includes the 48000 Plastic Rivet Setter and a 20-pack each of our four most popular rivet sizes: No. 58106, 58108, 58149 and 58150. A reclosable carton provides storage for rivets and tool. Weight: 1.5 lbs.

Klik-Lok™ KL-2 Plastic Rivet Setter/48005

This long-reach tool is just what today's professional needs for hard-to-reach spots, especially in automotive applications such as flexible bumpers, wheel wells, license plate brackets and bumper reinforcements. In addition to the tool's long reach, it offers one-stroke setting and a universal nosepiece that sets all plastic rivets. The tool is packaged in a reusable, heavy-duty vinyl pouch. Weight: .75 lb.

Professional Plastic Rivet Kit/48006

This kit includes the versatile KL-2 Plastic Rivet Setter, plus a 20-pack each of our four most popular rivet sizes: No. 58106, 58108, 58149 and 58150. A reclosable carton provides storage for rivets and tool. Weight: 1.5 lbs.

Hand Rivet Tools

HP-2®/39000

The HP-2 is the largest selling hand rivet tool in the industry. Known and trusted for durability, quality and performance, the HP-2 is often copied but never equaled. Its square shoulder fulcrum pin of cold-formed heat-treated steel prevents pin rotation that can elongate the engaging holes and cause premature tool failure in imitation tools. Other quality features include: precision die-case, high-strength aluminum alloy body; drop-forged carbon steel upper handle; and thick, cushion-molded vinyl grips for comfort. The HP-2 sets up to 3/16" steel rivets and comes with four mounted nosepieces (3/32", 1/8", 5/32" and 3/16") and a service wrench. Refer to the Riveter Capacity Chart on page 19 for specific capabilities. Weight: 1.2lbs.

Klik-Turn™ SP-1/39005

The SP-1 swivel head hand-held rivet tool features a patented positive-ratchet locking feature which will allow the swivel head section of the tool to turn 360° and hold in place in any of the forty-plus positions. The high-strength steel body and cast aluminum head complement this new design in a swivel head riveting tool. The SP-1 also includes built-in threaded nosepiece storage holes and a service wrench. The SP-1 sets up to 3/16" steel rivets. Refer to the Riveter Capacity Chart on page 19 for specific capabilities. Weight: 1.2lbs.

200 Kit™/39001

The deluxe hand riveter kit includes the HP-2 and 200 assorted Klik-Fast rivets in popular sizes. The molded plastic case houses and protects the tool, rivets and optional countersink double ended drill bit. Weight: 4 lbs.

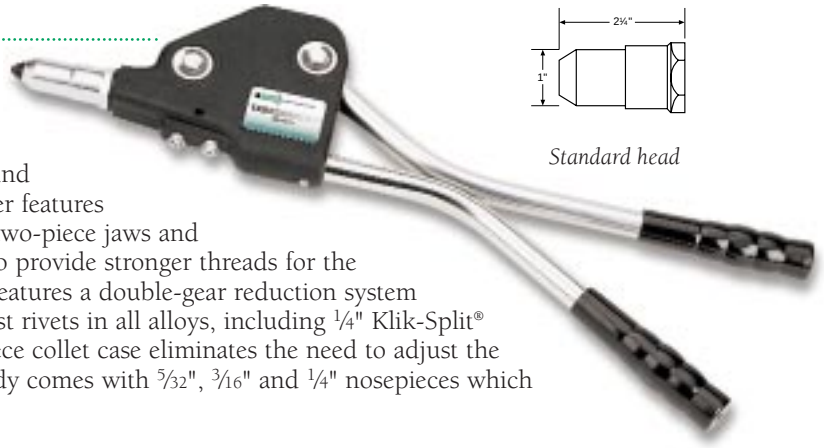
Stainless Steel Kit/39003

This kit is the same as our 39001, but contains 200 assorted Klik-Fast stainless steel rivets. Weight: 4 lbs.

The Kliker®/39040

The Kliker is a perfect medium-duty tool, setting all 1/8" to 5/32" steel, and 3/16" all aluminum Klik-Fast rivets. The Kliker comes packaged in a heavy-duty vinyl pouch with an assortment of Klik-Fast rivets and washers. Weight: 1 lb.

Big Daddy®/39031



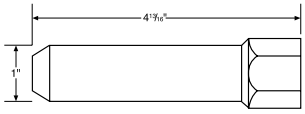
Standard head

The Big Daddy is Marson's most versatile and powerful hand riveter, taking the hard work out of setting large diameter blind rivets. Its extra-long handles provide excellent leverage and permit working a foot beyond natural reach. Other features include a patented bearing design, self-adjusting two-piece jaws and single-unit body construction with a steel insert to provide stronger threads for the nosepieces included. In addition, the Big Daddy features a double-gear reduction system which easily sets from 1/8" to 1/4" diameter Klik-Fast rivets in all alloys, including 1/4" Klik-Split® and 3/16" and 1/4" Klik-Lock™* rivets. And a one-piece collet case eliminates the need to adjust the tool when changing rivet diameters. The Big Daddy comes with 5/32", 3/16" and 1/4" nosepieces which are stored in the body. Weight: 3.75 lbs.

Big Daddy/39010

This is the same tool as 39031, but comes with 3/16", 1/4" and special 1/4" Klik-Split rivet nosepieces. Weight: 3.75 lbs.

Extended head



Big Daddy/39035

This is the same tool as 39010, but comes with 39009 attached, extending the tool's reach by an additional 2½". Weight: 4 lbs.

Big Daddy Extended Nosepiece Kit/39009

Just two installed parts extend the reach of 39031 or 39010 by an additional 2½". Weight: .25 lb.

Hand Rivet Tool Capacity Chart

Riveter Model	Steel					All Aluminum					Aluminum/ Steel					Stainless					Copper Steel	Klik-Lock®*		"T" Rivets	
	3/32	1/8	5/32	3/16	1/4	3/32	1/8	5/32	3/16	1/4	3/32	1/8	5/32	3/16	1/4	3/32	1/8	5/32	3/16	1/4	1/8	3/16	1/4	3/16	1/4
HP-2/39000	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•			•				
SP-1/39005	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•			•				
KR-II/39040	•	•	•			•	•	•	•		•	•	•			•					•				
BIG DADDY/39031		•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•	•	•	•	•	•

Hand Rivet Tools — Standard & Special Nosepieces

Tools	Sizes					Klik-Lock™* Sizes		T-Rivet Sizes	
	3/32"	1/8"	5/32"	3/16"	1/4"	3/16"	1/4"	3/16"	1/4"
39000	39131	39128	39130	39129					
39005	39160	39161	39162	39163					
39040	39131	39128	39130	39129					
39031		96024	96025	96026	96027	96031	96030	96029	96028

** When setting Marson Klik-Lock rivets,* ***no special nosepiece*** *is required.*

Air/Hydraulic Tools

39054/M-3

This heavy-duty air/hydraulic riveter with its newly designed ***steel forged*** head can hold up under demanding continuous use. The steel forged head allows for continuous full operating power and less internal wear. The M-3 will set blind rivets from ⅛" diameter in all alloys, up to 3/16". Included with the M-3 are standard ⅛", 5/32", and 3/16" nosepieces, a service wrench, swivel inlet air coupler and a mandrel collection bottle. The recommended airline pressure is 85-95 PSI. Weight: 4.2lbs.

39062/302-E

This durable riveter with its fully adjustable vacuum system holds the rivet in the nosepiece, allowing the operator to rivet at any angle with one hand free. The vacuum system also automatically collects the spent mandrel into a collection bottle. This creates a cleaner and safer work environment by preventing spent mandrels from falling to the floor or work surface.This tool can easily install 3/32" to 3/16" diameter rivets in all alloys, and ¼" diameter open-end rivets in aluminum/steel combination. A swivel air inlet for increased mobility when working is also included along with a push button trigger and molded frame which provides the operator with maximum comfort using minimal effort. The recommended airline pressure is 85-95 PSI. Weight: 4 lbs.

39055/M-3V

The Marson M-3V is capable of setting blind rivets from 3/32" diameter in all alloys up to 3/16". Additionally, it has an internal vacuum system, which allows the mandrel to be held in position while operating the tool at any angle. After setting, the spent mandrel is ejected into the mandrel collection bottle. The recommended airline pressure is 85-95 PSI.Weight: 4.6lbs.

39064/304-E

This is our most powerful air/hydraulic riveter, with its fully enclosed vacuum system that holds the rivet in the nosepiece, allowing the operator to rivet at any angle with one hand free. The vacuum system automatically collects the spent mandrel into a bottle, creating a cleaner, safer work environment by preventing spent mandrels from falling to the floor. A traction pulling power of 4200 lbs. allows this tool to easily set Klik-Lock™* and all other structural blind rivets. Its long 7/8" stroke enables the tool to set most rivets in one pull. In addition to the nosepieces for structural rivets, nosepieces to install 3/16" and ¼" standard rivets are also included along with a push button trigger and molded frame which provides the operator with maximum comfort using minimal effort. The recommended airline pressure is 85-95 PSI. Weight: 5½ lbs.

39058/M-4

This heavy-duty air/hydraulic riveter with its newly designed ***steel forged*** head can hold up under demanding continuous use. The steel forged head allows for continuous full operating power and less internal wear. The M-4 can set rivets from 3/32" through ¼" diameter in all alloys, and it also has the capability of setting 3/16" and ¼" T-Rivets/Klik-Split®, Klik-Lock™* and all other structural blind rivets *(special optional nosepieces may be required)*. The M-4 is supplied with 3/32", 5/32", 3/16" and ¼" standard nosepieces, service tools, swivel inlet air coupler and a mandrel collection bottle. The recommended airline pressure is 85-95 PSI. Weight: 6.6 lbs.

Extended head accessory for 302-E and 304-E

Tool	Description	Part Number
39062	*5" Extension head*	*721314*
39064	*5" Extension head*	*721922*

39070/IL-1

This durable in-line riveter with its fully adjustable vacuum system holds the rivet in the nosepiece in any riveting position and automatically ejects the mandrel into an attached container. The IL-1 is capable of setting rivet diameters from 3/32" through 3/16" in all alloys and easily hangs from any balancer This is an ideal tool for assembly line riveting. The recommended airline pressure is 85-95 PSI. Weight: 3lbs.

A balancer is available by special order for any of the above tools.

Air/Hydraulic Rivet Tools — Standard & Special Nosepieces

Tool	Standard					T-Rivets/Klik-Split®		Klik-Lock™*	
	3/32"	1/8"	5/32"	3/16"	1/4"	3/16"	1/4"	3/16"	1/4"
39054		95715	95716	95717					
39055	95761	95762	95763	95760					
39058	95897	95898	95899	95900	95835	95903	95905	95904	95906
39062	717006	717001	717002	717003	717005				
39064				717021	717022		717019	717016	717015
39070	717006	717001	717002	717003					

** When setting Marson Klik-Lock rivets,* ***no special nosepiece*** *is required.*

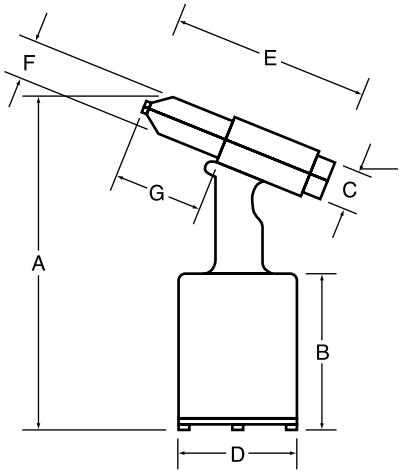
Air/Hydraulic Rivet Tools — Capacity Chart

Riveter Model	Steel					All Aluminum					Aluminum/ Steel					Stainless					Copper Steel	Klik-Lock™*		"T" Rivets	
	3/32	1/8	5/32	3/16	1/4	3/32	1/8	5/32	3/16	1/4	3/32	1/8	5/32	3/16	1/4	3/32	1/8	5/32	3/16	1/4	1/8	3/16	1/4	3/16	1/4
39054		•	•	•			•	•	•			•	•	•			•	•	•		•				
39055	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•		•				
39058	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
39062	•	•	•	•		•	•	•	•	•	•	•	•	•	•	•	•	•	•		•				
39064				•	•				•	•				•	•				•	•		•	•	•	•
39070	•	•	•	•		•	•	•	•		•	•	•	•		•	•	•	•		•				

** When setting Marson Klik-Lock rivets,* ***no special nosepiece*** *is required.*

Air/Hydraulic Rivet Tools — Dimensions

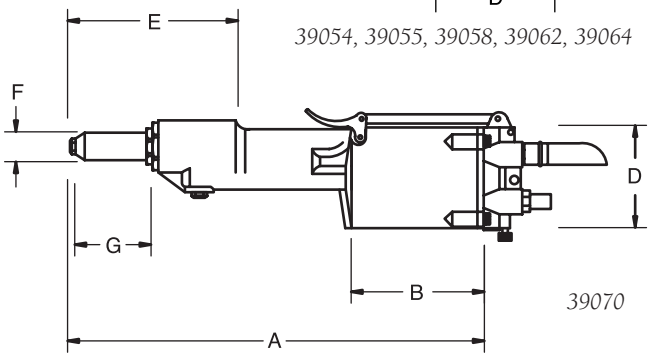
Tool	A	B	C	D	E	F	G	WT
39054	12"	6"	1¼"	3"	6"	1"	3"	4.2 lbs.
39055	11.5"	9.5"	1.75"	3"	7"	.915"	4"	4.6 lbs.
39058	12"	4.5"	1.5"	3.5"	7"	.987"	4.5"	6.6 lbs.
39062	11.125"	5"	2.375"	4.5"	13"	.828"	2.5"	4 lbs.
39064	13.125"	6"	2.375"	5.25"	13"	.9375"	2.5"	5.5 lbs.
39070	15"	4"		3.125"	9"	.875"	2.5"	3 lbs.



39054, 39055, 39058, 39062, 39064

Air/Hydraulic Rivet Tools — Specifications

Tool	Work Force	Avg. Air Consumption	Stroke
39054	85-95 psi 1,983 lbs./8,820 n	4 cfm	.551" 14 mm
39055	85-95 psi 1,940 lbs./8,629 n	4 cfm	.551" 14 mm
39058	85-95 psi 3,099 lbs./13,784 n	5 cfm	.748" 19 mm
39062	85-95 psi 2,000 lbs./8,896 n	5 cfm	.812" 21 mm
39064	85-95 psi 4,200 lbs./18,682 n	5 cfm	.875" 22 mm
39070	85-95 psi 2,100 lbs./9341 n	4 cfm	.590" 15 mm



39070

Threaded Insert Tools & Kits

Thread-Setter™ Tool/39200

This quality threaded insert installation tool features patented bearing design, comfortable hand grips and a locking chain. The 39200 installs all sizes of Klik Poly-Nuts and Klik Rivet-Nuts up to ¼-20 and 6mm threads in steel. The forged, heat treated steel upper handle, precision die-cast body of high strength aluminum alloy, patented fulcrum pin design and comfortable hand grips all combine to make the 39200 a rugged, durable tool. The tool is packaged in a reusable, heavy-duty vinyl pouch containing mandrels and nosepieces to set 8-32, 10-24 and 10-32 inserts. Weight: 1.2 lbs.

Mandrel/Nosepiece Chart

For tool & kit Nos. 39200, 34501, 39202, 39203, 39213 and 39214

Thread Size	Mandrel No.	Nospiece No.	Kit No.
6-32	39254	39261	39280
8-32	39255	39262	39281
10-24	39256	39263	39282
10-32	39257	39263	39283
¼-20	39258	Not Needed	
5/16-18	39259	Not Needed	
⅜-16	39260	Not Needed	
4mm	39266	39274	39285
5mm	39267	39273	39286
6mm	39268	Not Needed	
8mm	39269	Not Needed	

Thread-Setter Kit/34501

Model 34501 Thread-Setter Kit contains the 39200 thread-setter tool in a molded plastic case; mandrels and nosepieces for 6-32, 8-32, 10-24 sizes, and a mandrel for ¼-20. The kit also includes 103 assorted Klik Rivet-Nuts and Klik Poly-Nuts, instructions and wrench, all contained in a compartmentalized carrying case. Weight: 2.75 lbs.

Poly-Nut Kit/39202

Model 39202 Poly-Nut Kit contains the 39200 thread-setter tool in a molded plastic case with 8-32, 10-32 and ¼-20 mandrels and nosepieces, wrench and instructions. The kit contains 52 assorted Klik Poly-Nuts: 12 each 57425, 57435, 57445; 16 each 57455. Weight: 3 lbs.

Metric Poly-Nut Kit/39203

Model 39203 Metric Poly-Nut Kit contains the 39200 thread-setter tool in a molded plastic case with 4mm, 5mm, 6mm and 8mm mandrels and nosepieces, wrench and instructions. The kit contains 75 assorted Klik Poly-Nuts: 25 each 57407, 57409; 15 each 57411; 10 each 57413. Weight: 3.25 lbs.

Ribbed Rivet-Nut Kit/39215

Model 39215 Ribbed Rivet-Nut kit contains the 39200 thread-setter tool in a molded plastic case; mandrels, nosepieces, wrench & instructions for setting 8-32,10-24,10-32 and ¼-20 inserts. Includes 50 assorted Ribbed style Rivet-Nuts.Weight: 2.75 lbs.

Metric Ribbed Rivet-Nut Kit/39216

Model 39216 Ribbed Rivet-Nut kit contains the 39200 thread-setter tool in a molded plastic case with 4mm, 5mm, 6mm and 8mm mandrels and nosepieces, wrench and instructions. The kit also includes 50 assorted Ribbed style Rivet-Nuts. Weight: 2.75 lbs.

Steel Klik Thread-sert Kit/39214

Model 39214 Thread-sert Kit contains the 39200 thread-setter tool in a plastic case with 6-32, 8-32, 10-24, 10-32, ¼-20, 5/16-18 and ⅜-16 mandrels and nosepieces, wrench and instructions. The kit contains 62 assorted Steel Klik Thread-serts: 10 each 57810, 57820, 57830, 57840, 57850; 6 each 57871, 57881. Weight: 3.25 lbs.

Aluminum Klik Thread-sert Kit/39213

Model 39213 Thread-sert Kit contains the 39200 thread-setter tool in a molded plastic case with 6-32, 8-32, 10-24, 10-32, ¼-20, 5/16-18 and ⅜-16 mandrels and nosepieces, wrench and instructions. The kit contains 62 assorted Aluminum Klik Thread-serts: 10 each 57910, 57920, 57930, 57940, 57950; 6 each 57971, 57981. Weight: 3 lbs.

34604/325RN

Choose the 34604 for installing larger size threaded inserts. Model 34604 is a heavy-duty tool that will install 10-24 through ⅜"-16, and 5mm through 10mm threaded inserts in aluminum or steel. Quick-change mandrels, easily adjustable stroke. Weight: 4.25 lbs.

Mandrel/Nosepiece Chart

For 39221

Thread Size	Mandrel No.	Nospiece No.
4-40	88187	711104
6-32	88188	711156
8-32	88189	711105
10-24	88191	711106
10-32	88190	711106
¼-20	88160	711107
¼-28	88192	711107
5⁄16-18	88193	711108
5⁄16-24	88194	711108
⅜-16	88195	711109
⅜-24	88196	711109
½-13	88197	711110
½-20	88198	711110
3.5mm	88206	711893
4mm	88207	711894
5mm	88208	711895
6mm	88209	711896
8mm	88210	711897
10mm	88211	711898

For 39223

Thread Size	Mandrel No.	Nospiece No.
6-32	88708	711887
8-32	88709	711888
10-24	88710	711886
10-32	88711	711886
¼-20	88712	711885
4mm	88651	711806
5mm	88652	711807
6mm	88653	711808

Mandrel/Nosepiece Chart

For 34604

Thread Size	Mandrel No.	Nospiece No.	Kit No.
10-24	95635	95645	34615
10-32	95636	95645	34616
¼-20	95637	95647	34617
5⁄16-18	95638	95648	34618
⅜-16	95639	95649	34619
5mm	95630	95640	34625
6mm	95631	95641	34626
8mm	95632	95642	34627
10mm	95633	95643	34628

39221/150-SP

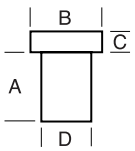
This spin-pull tool automatically threads the fastener onto the mandrel. Press the trigger and the fastener is installed. Reverse the trigger, and the mandrel spins out of the fastener. The 39221 features a totally adjustable stroke length to suit any grip range and a swivel air inlet for increased mobility. No complicated tear down is required to adjust the stroke or to change thread sizes...both adjustments are done outside of the tool. The 39221 handles rivet-nut sizes 4-40 through ½"-20 and 3.5mm through 10mm in aluminum or steel. 6-32 through ⅜-16 mandrels and nosepieces are included. Weight: 6 lbs.

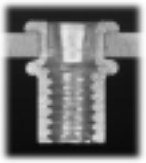
Tool also available with metric mandrels and nosepieces, part No. 39222.

39223/140-SP

Similar to the *39221/150-SP,* this lower cost alternative handles threaded insert sizes from 6-32 through ¼-20 and 4mm through 6mm in aluminum or steel. 6-32 through ¼-20 mandrels and nosepieces are included. Weight: 4.9 lbs.

Klik® Rivet-Nuts





Cross section view

Available in Steel-Zinc Plated or Aluminum Class 2B Threads

Klik Rivet-Nuts (Flat Head)

Klik Rivet-Nuts can be used in a wide range of applications and are designed to provide a very efficient and cost-effective method of placing permanent threads in thin materials. Installed from one side, Klik Rivet-Nuts are perfect for use in metal, fiberglass and rigid plastic previously too thin for tapped threads. Klik Rivet-Nuts provide a neat appearance and once in place, the internal threads are ready for a screw or bolt.

Lightweight tooling assures easy installation by the operator and reduces costs when compared with other methods. After installation, Klik Rivet-Nuts provide permanent, captive threads that do not allow loosening under vibration and will not rotate when attached to the mating material.

Klik Rivet-Nuts with large diameter heads can be used in soft materials which inherently offer little, if any, thread strength.

The flathead design provides the most bearing surface for higher torque applications. The larger flange extends above the material in which it is installed and provides a built-in spacer.

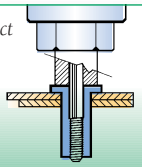
Klik Rivet-Nut (Flat Head) Specifications

Thread Size	Steel Marson Bulk Part#	Aluminum Marson Bulk Part #[1]	A Body Length +-.015"	B Head Dia. Ref. +-.015	C Head Height (NOM)	D Body Dia. Max +-.000-.004	Grip Range Min	Grip Range Max	Hole Size Min	Hole Size Max	Drill Size
6-32	57110	57210	.438	.325	.032	.189	.010	.075	.189	.193	# 12
8-32	57120	57220	.438	.357	.032	.221	.010	.075	.221	.226	# 2
8-32	57121	57221	.500	.357	.032	.221	.075	.120	.221	.226	# 2
10-24	57130	57230	.531	.406	.038	.250	.010	.080	.250	.254	¼"
10-24	57132	57232	.594	.406	.038	.250	.080	.130	.250	.254	¼"
10-32	57140	57240	.531	.406	.038	.250	.010	.080	.250	.254	¼"
10-32	57142	57242	.594	.406	.038	.250	.080	.130	.250	.254	¼"
1/4-20	57150	57250	.625	.475	.058	.332	.020	.080	.332	.338	Q
1/4-20	57152	57252	.687	.475	.058	.332	.080	.140	.332	.338	Q
1/4-20	57154	57254	.750	.475	.058	.332	.140	.200	.332	.338	Q
5/16-18	57171	57271	.750	.665	.062	.413	.030	.125	.413	.423	Z
5/16-18	57174	57274	.875	.665	.062	.413	.125	.200	.413	.423	Z
3/8-16	57181	57281	.844	.781	.088	.490	.030	.115	.490	.500	12.5mm
3/8-16	57184	57284	.938	.781	.088	.490	.115	.200	.490	.500	12.5mm

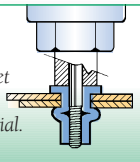
Rivet-Nut dimensions are in teal green indicating millimeters (mm).

4 Easy Steps for Installation

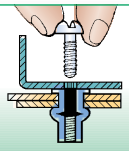
1 *Drill hole to correct diameter, thread fastener onto tool mandrel and insert into hole.*



2 *Actuate tool to properly set fastener into material.*

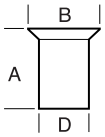


3 *Complete your fastening operation with a bolt or screw with the proper thread.*



4 *The positive riveting action of both Klik Rivet-Nuts and Klik Poly-Nuts provide consistent firm fastening. Push-out and shake-loose are virtually eliminated.*

Cross section view



Klik® Poly-Nuts

Available in Steel-Zinc Plated or Aluminum Class 2B Threads

Klik Poly-Nuts (Expander)

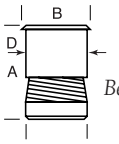
Klik Poly-Nuts can be used in a wide range of applications and are designed to provide a very efficient and cost-effective method of placing permanent threads in thin materials. Installed from one side, Klik Poly-Nuts are perfect for use in metal, fiberglass and rigid plastic previously too thin for tapped threads. Klik Poly-Nuts provide a nearly flush appearance and once in place, the internal threads are ready for a screw or bolt.

Lightweight tooling assures easy installation by the operator and reduces costs when compared with other methods. After installation, Klik Poly-Nuts provide permanent, captive threads that do not allow loosening under vibration and will not rotate when attached to the mating material.

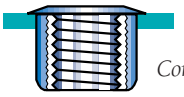
Klik Poly-Nut (Expander) Specifications

Thread Size	Steel Marson Bulk Part#	Aluminum Marson Bulk Part #	A Body Length +-.015"	B Head Dia. Ref. +-.015	D Body Dia. +-.005	Grip Range Min	Grip Range Max	Hole Size* Min	Hole Size* Max	Drill Size
6-32	57415	57510	.410	.287	.249	.020	.080	.250	.254	1/4"
8-32	57425	57520	.410	.287	.249	.020	.080	.250	.254	1/4"
10-24	57435	57530	.465	.320	.280	.020	.130	.281	.285	9/32"
10-32	57445	57540	.465	.320	.280	.020	.130	.281	.285	9/32"
1/4-20	57455	57550	.610	.415	.374	.030	.165	.375	.379	3/8"
5/16-18	57475	57575	.720	.540	.499	.030	.165	.500	.504	1/2"
3/8-16	57485	57585	.720	.540	.499	.030	.165	.500	.504	1/2"
4 mm	57407		.410	.287	.249	.020	.080	.250	.254	1/4"
5 mm	57409		.465	.320	.280	.020	.130	.281	.285	9/32"
6 mm	57411		.610	.415	.374	.030	.165	.375	.379	3/8"
8 mm	57413		.720	.540	.499	.030	.165	.500	.504	1/2"
10 mm	57414		.720	.540	.499	.030	.165	.500	.504	1/2"

∗ ***Note:*** *Hole size is critical for proper installation*



Before set



Completed application

Klik® Thread-Serts

Thread-Serts

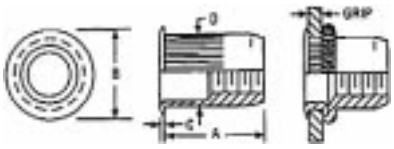
Klik Thread-Serts are a versatile threaded fastener that can be used in a variety of applications. Use Klik Thread-Serts in any thickness of metal or rigid material of at least 3/32" (.0937). Eliminate the need for tapping, welding and brazing. Klik Thread-Serts' design consists of an upper sleeve and a base which has both internal and external threads. During installation the base is drawn upwards inside the upper sleeve forcing a 360° contact between the sleeve and application material. No special preparation is needed; a drilled or punched hole is all that is required. Because of its unique setting ability, Klik Thread-Serts can be used in almost any thickness of material. Installation is made easy with a variety of tools and kits.

Thread-Sert Specifications

Thread Size	Steel Marson Bulk Part #	Aluminum Marson Bulk Part #	A* Body Length +-.005"	B Head Dia. +-.005	D* Body Dia. + -.002"	Material Thickness .0937"-.1562 Hole Size	Material Thickness .0937"-.1562 Drill Size	Material Thickness .1562-Infinity Hole Size	Material Thickness .1562-Infinity Drill Size
6-32	57810	57910	.375	.250	.215	0.221	#2	0.234	A
8-32	57820	57920	.375	.282	.246	0.250	1/4"	0.261	G
10-24	57830	57930	.375	.314	.277	0.281	9/32"	0.290	L
10-32	57840	57940	.375	.314	.277	0.281	9/32"	0.290	L
1/4-20	57850	57950	.510	.408	.372	0.391	25/64"	0.391	25/64"
5/16-18	57871	57971	.615	.537	.496	0.500	1/2"	0.516	33/64"
3/8-16	57881	57981	.740	.600	.559	0.562	9/16"	0.578	37/64"

** A and D dimensions are prior to setting*

Klik® Rivet-Nuts/Ribbed



Steel Yellow Zinc Dichromate, Class 2B Threads

Klik Rivet-Nuts/Ribbed

Klik Rivet-Nuts/Ribbed can be used in a wide range of applications and are designed to provide a very efficient and cost-effective method of placing permanent threads in thin materials. Installed from one side, Klik Rivet-Nuts/Ribbed are perfect for use in metal, fiberglass and rigid plastic previously too thin for tapped threads. Klik Rivet-Nuts/Ribbed provide a neat appearance and once in place, the internal threads are ready for a screw or bolt. Additional features of the ribbed rivet-nut include: Increased torque strength over conventional style, 360° *knurled* expansion after setting, vibration resistance and large flanged head which increases push out strength. Available in steel only with yellow zinc dichromate finish and in a wide range of sizes: 6-32 thru 1/4-20, 5/16-18 and 3/8-16, M4 thru M10. Standard and extended grip ranges are available in each size.

Lightweight tooling assures easy installation by the operator and reduces costs when compared with other methods. After installation, Klik Rivet-Nuts/Ribbed provide permanent, captive threads that do not allow loosening under vibration and will not rotate when attached to the mating material. Klik Rivet-Nuts/Ribbed with large diameter heads can be used in soft materials which inherently offer little, if any thread strength. The flathead design provides the most bearing surface for higher torque applications. The larger flange extends above the material in which it is installed and provides a built-in spacer.

Klik Rivet-Nut/Ribbed Specifications

Thread Size	Marson Bulk Part#	A Body Length +-.015" (mm)	B Head Dia. Ref. +-.015 (mm)	C Head Height (NOM) (mm)	D Body Dia. Max +-.000-.004 (mm)	Grip Range Min (mm)	Grip Range Max (mm)	Hole Size Required
6-32	57310	.433 10.9	.392 09.9	.028 0.71	.264 06.7	.020 0.50	.080 2.03	17/64
6-32	57312	.484 12.3	.392 09.9	.028 0.71	.264 06.7	.080 2.03	.130 3.30	17/64
8-32	57320	.433 10.9	.392 09.9	.028 0.71	.264 06.7	.020 0.50	.080 2.03	17/64
8-32	57321	.484 12.3	.392 09.9	.028 0.71	.264 06.7	.080 2.03	.130 3.30	17/64
10-24	57330	.488 12.3	.417 10.6	.028 0.71	.295 07.5	.020 0.50	.130 3.30	19/64
10-24	57332	.594 15.0	.417 10.6	.028 0.71	.295 07.5	.130 3.30	.225 5.71	19/64
10-32	57340	.488 12.3	.417 10.6	.028 0.71	.295 07.5	.020 0.50	.130 3.30	19/64
10-32	57342	.594 15.0	.417 10.6	.028 0.71	.295 07.5	.130 3.30	.225 5.71	19/64
1/4-20	57350	.590 14.9	.500 12.7	.028 0.71	.390 09.9	.027 0.68	.165 4.19	25/64
1/4-20	57354	.692 17.5	.500 12.7	.028 0.71	.390 09.9	.165 4.19	.260 6.60	25/64
5/16-18	57371	.690 17.5	.685 17.4	.032 0.81	.530 13.5	.027 0.68	.150 3.81	17/32
5/16-18	57374	.805 20.4	.685 17.4	.032 0.81	.530 13.5	.150 3.81	.312 7.92	17/32
3/8-16	57381	.690 17.5	.685 17.4	.032 0.81	.530 13.5	.027 0.68	.150 3.81	17/32
3/8-16	57382	.805 20.4	.685 17.4	.032 0.81	.530 13.5	.150 3.81	.312 7.92	17/32
M4	57360	.433 10.9	.392 09.9	.028 0.71	.264 06.7	.020 0.50	.080 2.03	17/64
M4	57365	.484 12.3	.392 09.9	.028 0.71	.264 06.7	.080 2.03	.130 3.30	17/64
M5	57385	.484 12.3	.417 10.5	.028 0.71	.295 07.5	.020 0.50	.130 3.30	19/64
M5	57384	.594 15.0	.417 10.5	.028 0.71	.295 07.5	.130 3.30	.225 5.71	19/64
M6	57386	.590 14.9	.500 12.7	.028 0.71	.390 09.9	.027 0.68	.165 4.19	25/64
M6	57387	.692 17.5	.500 12.7	.028 0.71	.390 09.9	.165 4.19	.260 6.60	25/64
M8	57388	.690 17.5	.685 17.4	.032 0.81	.530 13.5	.027 0.68	.150 3.81	17/32
M8	57389	.805 20.4	.685 17.4	.032 0.81	.530 13.5	.150 3.81	.312 7.92	17/32
M10	57390	.690 17.5	.685 17.4	.032 0.81	.530 13.5	.027 0.68	.150 3.81	17/32
M10	57391	.805 20.4	.685 17.4	.032 0.81	.530 13.5	.150 3.81	.312 7.92	17/32

Rivet-Nut dimensions are in teal green indicating millimeters (mm).

Conversion Tables

Inch-Metric Conversion Table

Inches			Inches		
Frac.	Dec.	mm	Frac.	Dec.	mm
1/64	0.015 625	0.3969	33/64	0.515 625	13.0969
1/32	0.031 250	0.7938	17/32	0.531 250	13.4938
3/64	0.046 875	1.1906	35/64	0.546 875	13.8906
1/16	0.062 500	1.5875	9/16	0.562 500	14.2875
5/64	0.078 125	1.9844	37/64	0.578 125	14.6844
3/32	0.093 750	2.3812	19/32	0.593 750	15.0812
7/64	0.109 375	2.7781	39/64	0.609 375	15.4781
1/8	0.125 000	3.1750	5/8	0.625 000	15.8750
9/64	0.140 625	3.5719	41/64	0.640 625	16.2719
5/32	0.156 250	3.9688	21/32	0.656 250	16.6688
11/64	0.171 875	4.3656	43/64	0.671 875	17.0656
3/16	0.187 500	4.7625	11/16	0.687 500	17.4625
13/64	0.203 125	5.1594	45/64	0.703 125	17.8594
7/32	0.218 750	5.5562	23/32	0.718 750	18.2562
15/64	0.234 375	5.9531	47/64	0.734 375	18.6531
1/4	0.250 000	6.3500	3/4	0.750 000	19.0500
17/64	0.265 625	6.7469	49/64	0.765 625	19.4469
9/32	0.281 250	7.1438	25/32	0.781 250	19.8437
19/64	0.296 875	7.5406	51/64	0.796 875	20.2406
5/16	0.312 500	7.9375	13/16	0.812 500	20.6375
21/64	0.328 125	8.3344	53/64	0.828 125	21.0344
11/32	0.343 750	8.7312	27/32	0.843 750	21.4312
23/64	0.359 375	9.1281	55/64	0.859 375	21.8281
3/8	0.375 000	9.5250	7/8	0.875 000	22.2250
25/64	0.390 625	9.9219	57/64	0.890 625	22.6219
13/32	0.406 250	10.3188	29/32	0.906 250	23.0188
27/64	0.421 875	10.7156	59/64	0.921 875	23.4156
7/16	0.437 500	11.1125	15/16	0.937 500	23.8125
29/64	0.453 125	11.5094	61/64	0.953 125	24.2094
15/32	0.468 750	11.9062	31/32	0.968 750	24.6062
31/64	0.484 375	12.3031	63/64	0.984 375	25.0031
1/2	0.500 000	12.7000	1	1.000 000	25.4000

Decimal Equivalents of Standard Sheet Gauges

No. of Gauge	Thickness in Thousandths	
	Aluminum (B&S)	Steel (U.S. Std.)
10	.1019	.1345
11	.0907	.1196
12	.0808	.1046
13	.0720	.0897
14	.0641	.0747
15	.0571	.0673
16	.0508	.0598
17	.0453	.0538
18	.0403	.0478
19	.0359	.0418
20	.0320	.0359
21	.0285	.0329
22	.0253	.0299
23	.0226	.0269
24	.0201	.0239
25	.0179	.0209
26	.0159	.0179
27	.0142	.0164
28	.0126	.0149
29	.0113	.0135
30	.0100	.0120

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